

ANVIL

PIPE FITTERS HANDBOOK



**ANVIL®**  
INTERNATIONAL

[www.anvilintl.com](http://www.anvilintl.com)

# PIPE FITTERS HANDBOOK

**Building Connections That Last**

NOT FOR RESALE

10.06

# TRUSTED FOR 150 YEARS

We built our reputation from the ground up.

Anvil's history stretches back to the mid 1800s, when a company named Grinnell® began providing its customers with the finest quality pipe products. Since 2000, those quality products and services—and the people who provide them—have been known as Anvil® International. Anvil customers receive the quality and integrity that have been building strong connections in both products and business relationships for over 150 years.



1850 Providence Steam & Gas Pipe Co. is formed. Frederick Grinnell purchases a controlling interest.

1909

Frederick Grinnell opens a piping products foundry in Cranston, RI, and eventually develops the Grinnell Supply Sales Division.

1919

General Fire Extinguisher Co. becomes Grinnell Co.

1969  
Grinnell Co. acquired by International Telephone and Telegraph.

1960  
Gruvlok® line of grooved fittings is introduced.

J.B. Smith™ and Catawissa™ join the Grinnell Supply Sales and Manufacturing division.

1994

Grinnell® is a registered trademark of Grinnell Corporation, a Tyco International Ltd. company.

## Focused Product Line:

Anvil® Malleable and Cast Iron Fittings

Anvil® Hangers, Supports and Struts

Anvil® Seamless Pipe Nipples

Anvil® Steel Pipe Couplings and Small Steel Fittings

Beck Welded Pipe Nipples

Merit® Tee-Lets and Drop Nipples

Gruvlok® Couplings, Fittings and Valves

SPF™ Cast Iron and Ductile Iron Fittings

SPF™ Malleable Iron Fittings

SPF™ Grooved Fittings and O'Let's

J.B. Smith Swage Nipples and Bull Plugs

Catawissa® Wing Unions and Check Valves

Anvil® International is the largest and most TODAY complete fitting and hanger manufacturer in the world.

Anvil® International acquires Star Pipe Products, 2004 Building and Construction Divisions (SPF) and forms AnvilStar™ Fire Products Division.

Anvil® International acquires Merit® Manufacturing 2001 and Beck Manufacturing.

The industry's trusted manufacturer of pipe 2000 products is renamed Anvil International, Inc.

Tyco sells the distribution and manufacturing operations known as "Grinnell Supply Sales", but keeps the Grinnell® trademark.

1999



BUILDING CONNECTIONS THAT LAST

ANVIL  
BRANDS:

GRUVLOK®

SPF/ANVL

Catawissa

ANVILStar  
The Products Division of Anvil International

J.B. STRUT

CANVIL

MERIT

ANVIL-STRUT

## ANVIL—BUILDING CONNECTIONS THAT LAST

### Anvil's focused product line consists of:

- Anvil® Malleable & Cast Iron Fittings
- SPFTM Malleable, Cast & Ductile Iron Fittings
- Anvil® Hangers, Supports
- Anvil-Strut™ Strut and Strut Fittings
- Beck Welded Pipe Nipples
- Anvil® Seamless Pipe Nipples
- SPFTM Steel Pipe Nipples
- Anvil® Steel Pipe Couplings & Small Steel Fittings
- Merit® Tee-Lets & Drop Nipples
- Gruvlok® Couplings, Fittings & Valves
- SPFTM Grooved Fittings & O'Let's
- J.B. Smith™ Swage Nipples & Bull Plugs
- Catawissa™ Wing Unions & Check Valves



### CONNECTING WITH CORE MARKETS:

From plumbing, mechanical, and fire protection, to mining, oil & gas, and OEMs, Anvil's focus has always been on providing real solutions for your applications. Our representatives are experts in the markets they serve, and understand the needs of your business. Anvil will work with you to find innovative products that meet your demands and exceed your expectations.

### CONNECTING WITH QUALITY:

Many things have changed during the 150 years in the industry - including the name above our door - but our quality and commitment remains the best in the business. Our ISO 9001:2000 manufacturing facilities produce a range of products unmatched by any other single manufacturer. Our responsive service sets an industry standard for dependability and effectiveness recognized around the world.

Whatever the word "quality" means to your business, Anvil guarantees it in everything we do.

### CONNECTING WITH WHOLESALERS:

Wholesale distribution has always been a vital aspect of Anvil's business. Our dedication to the wholesale channel - and our customers - is a driving force for our services. These relationships remain a primary focus of Anvil's innovation.

### CONNECTING WITH CUSTOMERS:

The most important connection that Anvil makes are the ones we make with our customers. In the field, over the phone, or on the web, we strive to provide our customers with the products, assistance, and service they need - when they need it. Responsive and accessible customer support is what makes the difference between simply delivering products, and delivering solutions.

**ANVIL—  
BUILDING CONNECTIONS THAT LAST.**

VISIT US ON THE WEB AT: [www.anvilintl.com](http://www.anvilintl.com)

**TABLE OF CONTENTS**

<b>GRUVLOK® PRODUCT INFORMATION . . .</b>	<b>6-148</b>
<b>INSTALLATION &amp; ASSEMBLY . . . . .</b>	<b>149-202</b>
<b>TECHNICAL INFORMATION . . . . .</b>	<b>203-315</b>
<b>GRUVLOK® PRODUCT INFORMATION:</b>	
<b>COUPLINGS FOR GROOVED-END PIPE</b>	
Fig. 7001 Standard Coupling . . . . .	6-8
Fig. 7011 Standard Coupling . . . . .	9
Fig. 7401 Rigidlok® Coupling . . . . .	10-11
Fig. 7000 Lightweight Coupling. . . . .	12-13
Fig. 7400 Rigidlite® Coupling . . . . .	14-15
Fig. 7003 Hingelok® Coupling . . . . .	16
Fig. 7010 Reducing Coupling. . . . .	17-18
Fig. 7012 Gruvlok Flanges . . . . .	19-21
Fig. 7013 Gruvlok Flanges . . . . .	22
Fig. 7240 Expansion Joints. . . . .	23
<b>BRANCH OUTLETS</b>	
Fig. 7042 Outlet Coupling. . . . .	24-25
Fig. 7045 Clamp-T, FPT Branch . . . . .	26-30
Fig. 7046 Clamp-T, Grooved Branch. . . . .	31-33
Fig. 7047, 7048 & 7049 Clamp-T, Cross . . . . .	34
Fig. 7044 Branch Outlet . . . . .	35
<b>FITTINGS FOR GROOVED-END PIPE</b>	
Fig. 7050 90° Elbow . . . . .	36
Fig. 7051 45° Elbow. . . . .	37
Fig. 7052 22½° Elbow . . . . .	38
Fig. 7053 11¼° Elbow . . . . .	39
Fig. 7050LR 90° Long Radius Elbow . . . . .	40

Fig. 7051LR 45° Long Radius Elbow. . . . .	41
Fig. 7063 Tee w/Threaded Branch. . . . .	42
Fig. 7061 Reducing Tee Standard. . . . .	43-45
Fig. 7064 Reducing Tee w/Thd Branch. . . . .	46-47
Fig. 7060 Tee. . . . .	48
Fig. 7076 Gr x Thd Concentric Reducers. . . . .	49
Fig. 7073 & Fig. 7097 Eccentric Reducers . . . . .	50-51
Fig. 7077, 7078 & 7079 Swaged Nipples . . . . .	52
Fig. 7072 Gr x Gr Concentric Reducers. . . . .	53-54
Fig. 7069 45° Lateral . . . . .	55
Fig. 7070 45° Reducing Lateral . . . . .	56-57
Fig. 7066 Tee Wye. . . . .	58-59
Fig. 7067 Reducing Tee Wye. . . . .	60
Fig. 7071 True Wye . . . . .	61
Fig. 7055 GR x MPT 90° Adapter Elbow . . . . .	62
Fig. 7056 GR x MPT 45° Adapter Elbow . . . . .	62
Fig. 7087 GR x FPT Female Thread Adapter . . . . .	63
Fig. 7050RF Grooved x 150# Flanged . . . . .	63
Fig. 7084 Gr x FI Nipples. . . . .	64
Fig. 7085 Gr x FI Nipples. . . . .	64
Fig. 7074 Cap . . . . .	65
Fig. 7075 Bull Plug. . . . .	66
Fig. 7068 Cross . . . . .	66
Fig. 7086 Gr x HOSE Nipples . . . . .	67
Fig. 7080 Adapter Nipples Gr x Gr . . . . .	67
Fig. 7081 Adapter Nipples Gr x MPT. . . . .	67
Fig. 7082 Adapter Nipples Gr x BEV. . . . .	67
Fig. 7062 Bullhead Tee Specialty Tees . . . . .	68
Fig. 7065 Standpipe Tee . . . . .	68
Fig. 7050DR 90° Drain Elbow . . . . .	69
Fig. 7091 End of the Line . . . . .	70
Fig. 7450 90° Short Pattern Elbow . . . . .	71
Fig. 7460 Short Pattern Tee . . . . .	71
Fig. 7050-3D 90° Elbow . . . . .	72
Fig. 7057-3D 60° Elbow. . . . .	72
Fig. 7051-3D 45° Elbow. . . . .	73
Fig. 7058-3D 30° Elbow . . . . .	73
Fig. 7052-3D 22½° Elbow . . . . .	74
Fig. 7053-3D 11¼° Elbow . . . . .	74
Fig. 7050-5D 90° Elbow . . . . .	75
Fig. 7057-5D 60° Elbow. . . . .	75
Fig. 7051-5D 45° Elbow. . . . .	76
Fig. 7058-5D 30° Elbow . . . . .	76
Fig. 7052-5D 22½° Elbow . . . . .	77
Fig. 7053-5D 11¼° Elbow . . . . .	77
Fig. 7050-6D 90° Elbow . . . . .	78
Fig. 7057-6D 60° Elbow . . . . .	78
Fig. 7051-6D 45° Elbow. . . . .	79
Fig. 7058-6D 30° Elbow . . . . .	79
Fig. 7052-6D 22½° Elbow . . . . .	80
Fig. 7053-6D 11¼° Elbow . . . . .	80
<b>VALVES &amp; ACCESSORIES</b>	
Series 7700 Butterfly Valve . . . . .	81-82
Series 7600 Butterfly Valve . . . . .	83
Series 8000GR Butterfly Valve . . . . .	84
Series 171 Brass Ball Valve. . . . .	85-86
Series 7500 Ball-valves . . . . .	87-88
Fig. 400G Silent Check Valve . . . . .	89

# TABLE OF CONTENTS

## TABLE OF CONTENTS CONT'D.

Series 7800 Check Valves . . . . .	90
GBV-G & GBV-A Balancing Valves . . . . .	91-92
GBV-S & GBV-T Globe Valves . . . . .	93
FTV-S & FTV-A Tri-Service Valves . . . . .	94-97
Fig. 7260 Tee Strainer . . . . .	98-99
Model 758G Grooved-End "Wye" Strainer . .	100
Model 768G Grooved-end "Wye" Strainer . .	101
Fig. 7250 Suction Diffuser . . . . .	102-104
Models GAV-15 Automatic Air Vents . . . . .	105
Models GAV-30 Automatic Air Vents . . . . .	106
Fig. AF21-GG Gr x Gr Flex Connector . . . . .	107
Fig. AF21-GF Gr x Fl Flex Connectors . . . . .	108
Fig. AF21-FF Fl x Fl Flex Connectors . . . . .	109

### HIGH PRESSURE SYSTEMS

Fig. 7004 HPR® Coupling . . . . .	110
Fig. 7004 EG® End Guard® Coupling . . . . .	111
Fig. 7050 EG High Pressure 90° LR Elbow . .	112
Fig. 7051 EG High Pressure 45° LR Elbow . .	112
Fig. 7060 EG High Pressure Tee . . . . .	112
Fig. 7022 EG High-pressure Header Tee . . . .	112
Fig. 7068 EG High Pressure Cross . . . . .	111

### GRUVLOK® ADVANCED COPPER METHOD

Fig. 7400 Rigidlite® Coupling . . . . .	113
Fig. 7012 Gruvlok Flanges . . . . .	114-115
Fig. 7550 90° Elbow . . . . .	116
Fig. 7551 45° Elbow . . . . .	116
Fig. 7560 Tees . . . . .	116
Fig. 7572 (Gr x Gr) Concentric Reducer . . .	117
Fig. 7561A (Gr x Gr x Gr) Reducing Tee . . .	118

## ANVIL PIPE FITTERS HANDBOOK

Fig. 7574 End Caps . . . . .	110
------------------------------	-----

Fig. 7564A Reducing Tee . . . . .	118
-----------------------------------	-----

Fig. 7575 Reducing Adapter . . . . .	120
--------------------------------------	-----

Fig. 7582 Transition Fitting . . . . .	120
--	-----

Series 7500B Bronze Ball Valve . . . . .	121-122
--	---------

### GRUVLOK DI-LOK® NIPPLES

Fig. 7088 - Groove by Thread . . . . .	123
--	-----

Fig. 7089 - Groove by Groove . . . . .	123
--	-----

Fig. 7090 - Thread by Thread . . . . .	123
--	-----

### GRUVLOK PLAIN-END FITTINGS

Fig. 7005 Roughneck® Coupling . . . . .	124
---	-----

Fig. 7050P 90° Elbow . . . . .	125
--------------------------------	-----

Fig. 7051P 45° Elbow . . . . .	125
--------------------------------	-----

Fig. 7060P Tee . . . . .	125
--------------------------	-----

Fig. 7068P Cross . . . . .	126
----------------------------	-----

Fig. 7061P Reducing Tee . . . . .	127
-----------------------------------	-----

Fig. 7069P 45° Lateral . . . . .	126
----------------------------------	-----

Fig. 7071P 90° True Wye . . . . .	126
-----------------------------------	-----

Fig. 7050LRP 90° LR Elbow . . . . .	128
-------------------------------------	-----

Fig. 7051LRP 45° LR Elbow . . . . .	128
-------------------------------------	-----

Fig. 7084P & Fig. 7085P Flange Nipples . .	129
--	-----

Fig. 7075P Bull Plug . . . . .	128
--------------------------------	-----

Fig. 7080P Plain x Grooved . . . . .	129
--------------------------------------	-----

Fig. 7081P Plain x Thread . . . . .	129
-------------------------------------	-----

Fig. 7082P Plain x Bevel . . . . .	129
------------------------------------	-----

Fig. 7077P Swaged Nipples . . . . .	130
-------------------------------------	-----

### HDPE COUPLINGS

Fig. 7305 HDPE Coupling . . . . .	131
-----------------------------------	-----

Fig. 7307 HDPE Transition Coupling . . . .	131
--	-----

Fig. 7312 HDPE Flange Adapter . . . . .	132
---	-----

### SOCK-IT® PIPING METHOD FITTINGS

Fig. 7100 90° Elbow . . . . .	133
-------------------------------	-----

Fig. 7101 90° Reducing Elbow . . . . .	135
--	-----

Fig. 7103 Straight Tee . . . . .	134
----------------------------------	-----

Fig. 7105 Reducing Outlet Tee . . . . .	136
---	-----

Fig. 7106 Reducing Tee . . . . .	137
----------------------------------	-----

Fig. 7107 Coupling . . . . .	138
------------------------------	-----

### STAINLESS STEEL METHOD

Fig. 7400SS Rigidlite® Coupling . . . . .	139
---	-----

Series 7500SS Grooved-End Ball Valve .	140-141
--	---------

Fig. 7050SS 90° SS Elbow . . . . .	142
------------------------------------	-----

Fig. 7051SS 45° SS Elbow . . . . .	142
------------------------------------	-----

Fig. 7060SS SS Tees . . . . .	143
-------------------------------	-----

Fig. 7074SS SS Caps . . . . .	143
-------------------------------	-----

Fig. 7061SS SS Reducing Tees . . . . .	144
--	-----

Fig. 7072SS SS Concentric Reducers . . .	145
--	-----

### ROLL GROOVERS

Model 1007 & 3007 Roll Groovers . . . . .	146
---	-----

Model 3006 & 3006C Roll Groovers . . . .	147
--	-----

### FITTING O.D. SIZE CHART & FLOW DATA . . . . .

### LISTINGS AND APPROVALS . . . . .

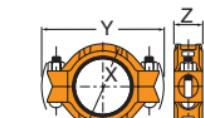
	315
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Note: Every effort has been made to assure the accuracy of dimension data. We cannot accept responsibility for inaccuracies resulting from undetected errors or omissions. Contact your Anvil Rep. to verify information.

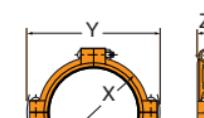
# Couplings

**FIG. 7001**

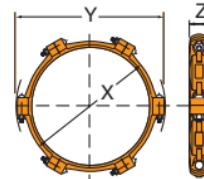
STANDARD COUPLING



SIZES 1" - 14"



SIZES 16" - 24"



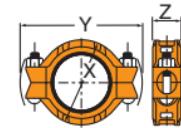
SIZES 28" - 30"

FIGURE 7001 STANDARD COUPLING DIMENSIONS (CONTINUED ON NEXT PAGE)

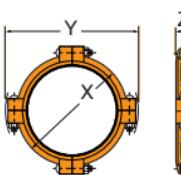
Nom. Size	O.D.	Max. Work. Pressure	Max. End Load	Range of Pipe End Separation	Deflection from		Coupling Dimensions			Bolt Dimensions*		Specified Torque §		Approx. Wt. Ea.	
					Per Coupling	of Pipe	Degrees	In./ft.- mm/mm	In./mm	In./mm	In./mm	Qty.	Size	Min.	Max.
In./ DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm											
1	1.315	1000	1,358	0-1/8	5° 26'	1.14	2 1/2	4 1/2	1 7/8	2	3/8 x 2 1/4	30	45	1.3	
25	33.4	68.9	6.04	0-3.2		94.7	64	114	48		M10 x 57	40	60	0.6	
1 1/4	1.660	1000	2,164	0-1/8	4° 19'	0.90	2 3/4	4 1/2	1 7/8	2	3/8 x 2 1/4	30	45	1.4	
32	42.2	68.9	9.63	0-3.2		75.3	70	114	48		M10 x 57	40	60	0.6	
1 1/2	1.900	1000	2,835	0-1/8	3° 46'	0.79	3	4 5/8	1 7/8	2	3/8 x 2 1/4	30	45	1.5	
40	48.3	68.9	12.61	0-3.2		65.7	76	117	48		M10 x 57	40	60	0.7	
2	2.375	1000	4,430	0-1/8	3° 1'	0.63	3 5/8	6 1/8	1 7/8	2	1/2 x 3	80	100	3.1	
50	60.3	68.9	19.71	0-3.2		52.6	92	156	48		M12 x 76	110	150	1.4	
2 1/2	2.875	1000	6,492	0-1/8	2° 29'	0.52	4 1/4	6 1/2	1 7/8	2	1/2 x 3	80	100	3.7	
65	73.0	68.9	28.88	0-3.2		43.3	108	165	48		M12 x 76	110	150	1.7	
3 O.D.	2.996	1000	7,050	0-1/8	2° 23'	0.50	4 1/4	6 3/4	1 7/8	2	1/2 x 3	80	100	4.3	
76.1	76.1	68.9	31.36	0-3.2		41.6	108	171	48		M12 x 76	110	150	2.0	
3	3.500	1000	9,621	0-1/8	2° 3'	0.43	4 7/8	7 1/8	1 7/8	2	1/2 x 3	80	100	4.3	
80	88.9	68.9	42.80	0-3.2		35.8	124	181	48		M12 x 76	110	150	2.0	
3 1/2	4.000	1000	12,566	0-1/8	1° 48'	0.38	5 1/4	8 1/4	1 7/8	2	5/8 x 3 1/2	100	130	5.1	
65	101.6	68.9	55.90	0-3.2		31.4	133	210	48		M16 x 89	135	175	2.3	
4	4.500	1000	15,904	0-1/4	3° 11'	0.67	6 1/4	8 3/4	2	2	5/8 x 3 1/2	100	130	6.8	
100	114.3	68.9	70.75	0-6.4		55.5	159	222	51		M16 x 89	135	175	3.1	

FIG. 7001, CONT'D.

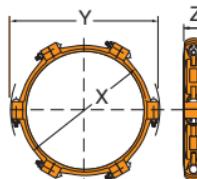
## STANDARD COUPLING



SIZES 1" - 14"



SIZES 16" - 24"



SIZES 28" - 30"

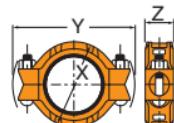
FIGURE 7001 STANDARD COUPLING DIMENSIONS (CONTINUED ON NEXT PAGE)

Nom. Size	O.D.	Max. Work. Pressure	Max. End Load	Range of Pipe End Separation	Deflection from		Coupling Dimensions			Bolt Dimensions*		Specified Torque §		Approx. Wt. Ea.	
					Per Coupling	of Pipe	In./ft.- mm/m	In./mm	In./mm	In./mm	Qty.	Size	Min.	Max.	
In./ DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees										
5	5.563	1000	24,306	0-1/4	2° 35'	0.54	7 1/4	11 1/4	2	2	3/4 x 4 1/2	130	180	9.6	
125	141.3	68.9	108.12	0-6.4		45.1	184	286	51		M20 x 110	175	245	4.4	
6 1/2 O.D.	6.500	1000	33,183	0-1/4	2° 12'	0.46	8 1/4	11 3/4	2	2	3/4 x 4 1/2	130	180	11.8	
165.1	165.1	68.9	147.61	0-6.4		38.4	210	298	51		M20 x 110	175	245	5.4	
6	6.625	1000	34,472	0-1/4	2° 10'	0.45	8 5/8	11 3/4	2	2	3/4 x 4 1/2	130	180	11.8	
150	168.3	68.9	153.34	0-6.4		37.8	219	298	51		M20 x 110	175	245	5.4	
8	8.625	800	46,741	0-1/4	1° 40'	0.35	11	14 3/8	2 5/8	2	7/8 x 5 1/2	180	220	21.7	
200	219.1	55.2	207.91	0-6.4		29.1	279	365	60		M22 x 140	245	300	9.8	
10	10.750	800	72,610	0-1/4	1° 20'	0.28	13 1/8	16 5/8	2 5/8	2	7/8 x 5 1/2	180	220	27.0	
250	273.0	55.2	322.99	0-6.4		23.3	333	422	67		M22 x 140	245	300	12.2	
12	12.750	800	102,141	0-1/4	1° 7'	0.23	15 1/2	18 5/8	2 5/8	2	7/8 x 6	180	220	35.0	
300	323.9	55.2	454.35	0-6.4		19.5	394	473	67		M22 x 150	245	300	15.9	
14	14.000	300	46,181	0-1/4	1° 2'	0.22	16 1/8	20 1/2	3	2	7/8 x 5 1/2	180	220	37.0	
350	355.6	20.7	205.43	0-6.4		18.0	410	521	76		M22 x 140	245	300	16.8	
16	16.000	300	60,319	0-1/4	0° 54'	0.19	18 1/8	22 7/8	3	4	1 x 4	200	250	50.0	
400	406.4	20.7	268.31	0-6.4		15.7	460	581	76		*	-	-	22.7	
18	18.000	300	76,341	0-1/4	0° 48'	0.17	21 1/8	25 3/8	3 1/8	4	1 x 4	200	250	72.0	
450	457.2	20.7	339.58	0-6.4		14.0	537	645	79		*	-	-	32.7	

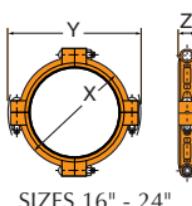
# Couplings

**FIG. 7001, CONT'D.**

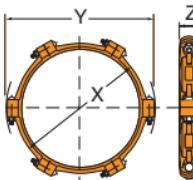
STANDARD COUPLING



SIZES 1" - 14"



SIZES 16" - 24"



SIZES 28" - 30"

**FIGURE 7001 STANDARD COUPLING DIMENSIONS (CONTINUED FROM PREVIOUS PAGE)**

Nom. Size	O.D.	Max. Work. Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\frac{1}{2}$		Coupling Dimensions			Bolt Dimensions*		Specified Torque $\frac{1}{2}$		Approx. Wt. Ea.
					Per Coupling	Per. In/Ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./ DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	In./ft. - mm/m	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N-M	In./mm	Lbs./kN
20	20.000	300	94,248	0-1/4	0° 43'	0.15	23	28 1/4	3 1/8	4	1 1/8 x 4 1/2	225	275	82.0
500	508.0	20.7	419.23	0-6.4		12.5	584	718	79	*	-	-	-	37.2
24	24.000	300	135,717	0-1/4	0° 36'	0.13	27	32 5/8	3 1/8	4	1 1/8 x 4 1/2	225	275	90.0
600	609.6	20.7	603.70	0-6.4		10.5	686	822	79	*	-	-	-	40.8
28" O.D.	28.875	150	98,226	0-1/4	0° 33'	0.12	33 1/2	35 1/2	3 1/8	6	1 x 5 1/2	200	250	105.0
733.4	733.4	10.3	436.93	0-6.4		9.6	851	902	79	*	-	-	-	47.6
30" O.D.	31.00	150	113,215	0-1/4	0° 28'	0.10	33 3/4	38 1/4	3 5/8	6	1 x 5 1/2	200	250	137.0
787.4	787.4	10.3	503.61	0-6.4		8.1	857	972	92	*	-	-	-	62.1

\* Available in ANSI or metric bolt sizes only as indicated.

For additional details see "Coupling Data Chart Notes" on page 264.

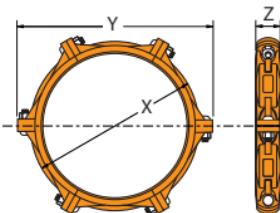
§ – For additional Bolt Torque information on page 202.

See Installation & Assembly directions on pages 150-151.

Not for use in copper systems.

**FIG. 7011**

STANDARD COUPLING

**FIGURE 7011 STANDARD COUPLING**

Nominal Size	O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\epsilon$		Coupling Dimensions			Coupling Bolts*		Specified		Approx. Wt. Ea.
					Per Coupling	Per in./ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	mm/m	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./M-M	Lbs./Kg	
30 O.D. 750	30.000 762.0	300 20.7	212,058 943.2	0 -3/16 0 - 4.8	0° 40'	0.14 11.5	34 864	39½ 1003	5 127	6	1 ¼ x 4 ¾	600 -	800 -	200 90.9

Working pressure and end load values are for standard wall pipe.

Roll and Cut Grooving Specifications can be found in the technical data section.

See technical data section for design factors.

For additional details see "Coupling Data Chart Notes" on page 264.

§ – For additional Bolt Torque information on page 202.

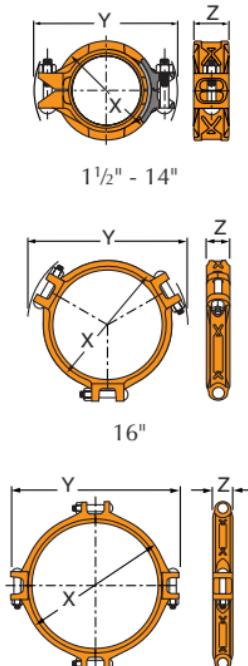
\* Available in ANSI bolt sizes only as indicated.

See Installation & Assembly directions on pages 152-153.

# Couplings

**FIG. 7401**

RIGIDLOK® COUPLING



18" - 24"

Nominal Size	O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts*		Specified Torque \$		Approx. Wt. Ea.
					X	Y	Z	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm		In./mm	Ft.-Lbs./N·M	Lbs./Kg		
1 1/2 40	1.900 48.3	750 51.7	2,126 9.46	0 - 1/8 0 - 3.2	3 76	5 1/8 130	1 1/8 48	2	3/8 x 2 1/4 M10 x 57	30 40	45 60	1.8 0.8
2 50	2.375 60.3	750 51.7	3,323 14.78	0 - 1/8 0 - 3.2	3 1/2 89	5 5/8 143	1 1/8 48	2	3/8 x 2 1/2 M10 x 63	30 40	45 60	2.4 1.1
2 1/2 65	2.875 73.0	750 51.7	4,869 21.66	0 - 1/8 0 - 3.2	4 102	6 1/8 156	1 1/8 48	2	3/8 x 2 1/2 M10 x 63	30 40	45 60	2.9 1.3
3 O.D. 76.1	2.996 76.1	750 51.7	5,207 23.52	0 - 1/8 0 - 3.2	4 1/8 105	6 1/8 156	1 1/8 48	2	1/2 x 3 M12 x 76	80 110	100 150	3.4 1.5
3 80	3.500 88.9	750 51.7	7,216 32.10	0 - 1/8 0 - 3.2	4 3/4 121	7 1/4 184	1 1/8 48	2	1/2 x 3 M12 x 76	80 110	100 150	3.6 1.6
4 100	4.500 114.3	750 51.7	11,928 53.06	0 - 1/4 0 - 6.4	5 1/8 149	8 3/8 213	2 1/8 54	2	1/2 x 3 M12 x 76	80 110	100 150	5.0 2.3
5 1/2 O.D. 139.7	5.500 139.7	750 51.7	17,819 79.26	0 - 1/4 0 - 6.4	7 178	9 9/16 248	2 1/8 54	2	5/8 x 3 1/2 M16 x 85	100 135	130 175	6.9 3.1
5 125	5.563 141.3	750 51.7	18,229 81.09	0 - 1/4 0 - 6.4	7 178	10 254	2 1/8 54	2	5/8 x 3 1/2 M16 x 85	100 135	130 175	6.9 3.1
6 1/2 O.D. 165.1	6.500 165.1	750 51.7	24,887 110.70	0 - 1/4 0 - 6.4	8 203	11 279	2 1/8 54	2	5/8 x 3 1/2 M16 x 85	100 135	130 175	7.6 3.4
6 150	6.625 168.3	750 51.7	25,854 115.00	0 - 1/4 0 - 6.4	8 1/8 206	11 1/8 283	2 1/8 54	2	5/8 x 3 1/2 M16 x 85	100 135	130 175	7.9 3.6

FIG. 7401, CONT'D.

RIGIDLOK® COUPLING

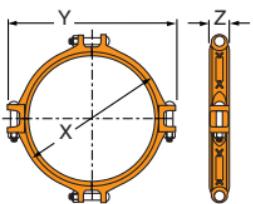
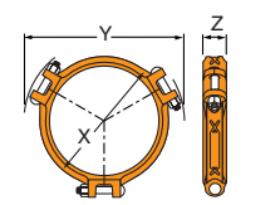
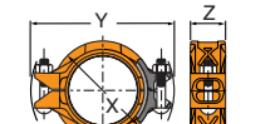


FIGURE 7401 RIGIDLOK COUPLING (CONTINUED FROM NEXT PAGE)

Nominal Size	O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts*		Specified Torque §		Approx. Wt. Ea.
					X	Y	Z	Qty.	Size	In./mm	Fl.-Lbs./N-M	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm						
8	8.625	600	35,056	0 - 1/4	10 1/2	14 1/8	2 5/8	2	3/4 x 4 1/2	130	180	15.9
200	219.1	51.7	155.94	0 - 6.4	267	359	67		M20 x 110	175	245	7.2
10	10.750	500	45,381	0 - 1/4	12 1/8	17 1/2	2 5/8	2	1 x 6	200	250	25.6
250	273.1	51.7	201.87	0 - 6.4	327	445	67		M24 x 150	270	340	11.6
12	12.750	400	51,070	0 - 1/4	15	19 1/2	2 5/8	2	7/8 x 6	180	220	30.5
300	323.9	51.7	227.17	0 - 6.4	381	495	67		M22 x 150	245	300	13.8
14	14.000	300	46,181	0 - 1/4	16 1/4	19 3/4	3	2	7/8 x 5 1/2	180	220	36.1
350	355.6	20.7	205.43	0 - 6.4	413	502	76			245	300	16.4
16	16.000	300	60,319	0 - 1/4	18 1/8	22 1/4	3	3	7/8 x 5 1/2	180	220	42.0
400	406.4	20.7	268.31	0 - 6.4	460	565	76			245	300	19.1
18	18.000	300	76,341	0 - 1/4	20 1/2	24 3/8	3 1/8	4	1 x 4	200	250	51.6
450	457.2	20.7	339.58	0 - 6.4	521	619	79			270	340	23.4
20	20.000	300	94,248	0 - 1/4	23	26 7/8	3 1/8	4	1 x 4	200	250	68.3
500	508.0	20.7	419.23	0 - 6.4	581	683	79			270	340	31.0
24	24.000	250	113,097	0 - 1/4	27 1/8	30 7/8	3 1/8	4	1 x 4	200	250	89.3
600	609.6	17.2	503.08	0 - 6.4	689	784	79			270	340	40.5

\* Available in ANSI or metric bolt sizes only as indicated.

Not for use in copper systems.

For additional details see "Coupling Data Chart Notes" on page 264.

§ - For additional Bolt Torque information on page 202.

See Installation &amp; Assembly directions on pages 154-155.

# Couplings

## FIG. 7000

LIGHTWEIGHT FLEXIBLE COUPLING

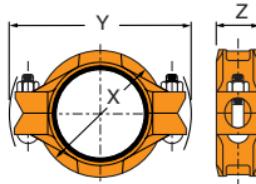


FIGURE 7000 COUPLING (CONTINUED ON NEXT PAGE)

Nom. Size	O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\frac{1}{4}$		Coupling Dimensions			Coupling Bolts		Specified Torque $\frac{1}{4}$		Approx. Wt. Ea.
					Per Coupling	Per in./ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./ DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	mm/m	In./mm	In./mm	In./mm	In./mm	Fl.-Lbs./N·M	Lbs./Kg		
1	1.315	600	815	0 - $\frac{1}{8}$	5° 26'	1.14	2 $\frac{3}{8}$	4 $\frac{1}{4}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	30	45	1.3
25	33.4	41.4	3.62	0 - 3.2		94.7	60	108	44		M10 x 57	40	60	0.6
1 $\frac{1}{4}$	1.660	600	1,299	0 - $\frac{1}{8}$	4° 19'	0.90	2 $\frac{3}{4}$	4 $\frac{1}{8}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	30	45	1.4
32	42.2	41.4	5.78	0 - 3.2		75.3	70	111	44		M10 x 57	40	60	0.6
1 $\frac{1}{2}$	1.900	600	1,701	0 - $\frac{1}{8}$	3° 46'	0.79	3	4 $\frac{5}{8}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	30	45	1.5
40	48.3	41.4	7.57	0 - 3.2		65.7	76	117	44		M10 x 57	40	60	0.7
2	2.375	600	2,658	0 - $\frac{1}{8}$	3° 1'	0.63	3 $\frac{1}{2}$	5 $\frac{1}{2}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	30	45	1.7
50	60.3	41.4	11.82	0 - 3.2		52.6	89	140	44		M10 x 57	40	60	0.8
2 $\frac{1}{2}$	2.875	600	3,895	0 - $\frac{1}{8}$	2° 29'	0.52	4	5 $\frac{1}{4}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	30	45	1.9
65	73.0	41.4	17.33	0 - 3.2		43.3	102	146	44		M10 x 57	40	60	0.9
3 O.D.	2.996	600	4,230	0 - $\frac{1}{8}$	2° 23'	0.50	4	6 $\frac{1}{8}$	1 $\frac{3}{4}$	2	3 $\frac{1}{8}$ x 2 $\frac{1}{4}$	80	100	2.3
76.1	76.1	41.4	18.82	0 - 3.2		41.6	102	156	44		M10 x 57	110	150	1.0
3	3.500	600	5,773	0 - $\frac{1}{8}$	2° 3'	0.43	4 $\frac{1}{8}$	6 $\frac{1}{4}$	1 $\frac{3}{4}$	2	1 $\frac{1}{2}$ x 2 $\frac{3}{4}$	80	100	2.9
80	88.9	41.4	25.68	0 - 3.2		35.8	117	171	44		M12 x 70	110	150	1.3
3 $\frac{1}{2}$	4.000	600	7,540	0 - $\frac{1}{8}$	1° 48'	0.38	5 $\frac{1}{8}$	7 $\frac{1}{8}$	1 $\frac{3}{4}$	2	1 $\frac{1}{2}$ x 3	80	100	3.1
90	101.6	41.4	33.54	0 - 3.2		31.4	130	194	44		M12 x 76	110	150	1.4
4 $\frac{1}{4}$ O.D.	4.250	600	8,512	0 - $\frac{1}{4}$	3° 22'	0.70	5 $\frac{1}{2}$	7 $\frac{1}{4}$	2	2	1 $\frac{1}{2}$ x 3	80	100	4.0
108.0	108.0	41.4	37.86	0 - 6.4		58.7	140	197	51		M12 x 76	110	150	1.8
4	4.500	600	9,543	0 - $\frac{1}{4}$	3° 11'	0.67	5 $\frac{1}{8}$	8 $\frac{1}{8}$	2	2	1 $\frac{1}{2}$ x 3	80	100	4.6
100	114.3	41.4	42.45	0 - 6.4		55.5	149	206	51		M12 x 76	110	150	2.1

**FIG. 7000, CONT'D.**

LIGHTWEIGHT FLEXIBLE COUPLING

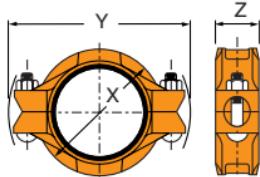


FIGURE 7000 COUPLING (CONTINUED FROM PREVIOUS PAGE)

Nom. Size	O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\frac{1}{4}$		Coupling Dimensions			Coupling Bolts		Specified Torque $\frac{1}{4}$		Approx. Wt. Ea.
					Per Coupling	Per in./ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./ DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	mm/m	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N-M	Lbs./Kg	
5 $\frac{1}{4}$ O.D. 133.0	5.236 133.0	500 34.5	10,766 47.89	0 - 1/4 0 - 6.4	2° 44' 47.7	0.57 165	6 $\frac{1}{2}$ 232	9 $\frac{1}{8}$ 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	5.7 2.6
5 $\frac{1}{2}$ O.D. 139.7	5.500 139.7	500 34.5	11,879 52.84	0 - 1/4 0 - 6.4	2° 36' 45.4	0.54 171	6 $\frac{3}{4}$ 238	9 $\frac{3}{8}$ 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	6 2.7
5 125	5.563 141.3	500 34.5	12,153 54.06	0 - 1/4 0 - 6.4	2° 35' 45.1	0.54 178	7 244	9 $\frac{5}{8}$ 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	6.1 2.8
6 $\frac{1}{4}$ O.D. 159.0	6.259 159.0	500 34.5	15,384 68.43	0 - 1/4 0 - 6.4	2° 17' 39.8	0.48 191	7 $\frac{1}{2}$ 264	10 $\frac{1}{8}$ 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	6.7 3.0
6 $\frac{1}{2}$ O.D. 165.1	6.500 165.1	500 34.5	16,592 73.80	0 - 1/4 0 - 6.4	2° 12' 34.8	0.46 197	7 $\frac{3}{4}$ 273	10 $\frac{1}{4}$ 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	7.0 3.2
6 150	6.625 168.3	500 34.5	17,236 76.67	0 - 1/4 0 - 6.4	2° 10' 37.8	0.45 203	8 279	11 51	2	2	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$ M16 x 85	100 135	130 175	8.1 3.7
8 200	8.625 219.1	500 34.5	29,213 129.95	0 - 1/4 0 - 6.4	1° 40' 29.1	0.35 264	10 337	13 $\frac{1}{4}$ 60	2 $\frac{3}{8}$	2	3 $\frac{1}{4}$ x 4 $\frac{1}{2}$ M20 x 110	130 175	180 245	14.2 6.4

For additional details see "Coupling Data Chart Notes" on page 264.

 $\frac{1}{4}$  For additional Bolt Torque information on page 202.

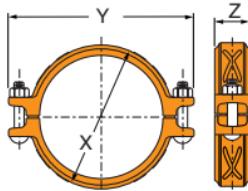
Not for use in copper systems.

See Installation &amp; Assembly directions on page 156-157.

# Couplings

**FIG. 7400**

RIGIDLITE® COUPLING

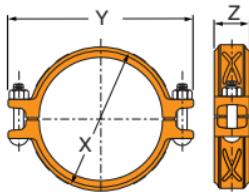


**FIGURE 7400 RIGIDLITE® COUPLING (CONTINUED ON NEXT PAGE)**

Nominal Size	O.D.	Max. Wk. Pressure	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts		Specified Torque §	Approx. Wt. Ea.
					X	Y	Z	Qty.	Size		
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm			In./mm	Ft.-Lbs./N·M	Lbs./Kg
1	1.315	300	407	0 - 1/8	2 1/4	4 1/2	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
25	33.4	20.7	1.81	0 - 3.2	57	114	44				0.5
1 1/4	1.660	300	649	0 - 1/8	2 5/8	4 3/4	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
32	42.2	20.7	2.89	0 - 3.2	67	121	44				0.6
1 1/2	1.900	300	851	0 - 1/8	2 7/8	4 7/8	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
40	48.3	20.7	3.78	0 - 3.2	73	124	44				0.6
2	2.375	300	1,329	0 - 1/8	3 1/4	5 1/2	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
50	60.3	20.7	5.91	0 - 3.2	83	140	44				0.7
2 1/2	2.875	300	1,948	0 - 1/8	3 7/8	6	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
65	73.0	20.7	8.66	0 - 3.2	98	152	44				0.9
3 O.D.	2.996	300	2,115	0 - 1/8	4	5 5/8	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60
76.1	76.1	20.7	9.41	0 - 3.2	102	149	44				0.9
3	3.500	300	2,886	0 - 1/8	4 1/2	6 3/4	1 3/4	2	5/8 x 2 3/4 M10 x 70	30 40	45 60
80	88.9	20.7	12.84	0 - 3.2	114	171	44				1.0
4	4.500	300	4,771	0 - 1/4	5 5/8	7 3/4	1 7/8	2	5/8 x 2 3/4 M10 x 70	30 40	45 60
100	114.3	20.7	21.22	0 - 6.4	143	197	48				3.1

**FIG. 7400, CONT'D.**

RIGIDLITE® COUPLING

**FIGURE 7400 RIGIDLITE® COUPLING (CONTINUED FROM PREVIOUS PAGE).**

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Max. Wk. Pressure <i>PSI/bar</i>	Max. End Load <i>Lbs./kN</i>	Range of Pipe End Separation <i>In./mm</i>	Coupling Dimensions			Coupling Bolts		Specified Torque §		Approx. Wt. Ea. <i>Lbs./Kg</i>
					X <i>In./mm</i>	Y <i>In./mm</i>	Z <i>In./mm</i>	Qty.	Size	Min.	Max.	
5½ O.D. 139.7	5.500 139.7	300 20.7	7,127 31.70	0 - ¼ 0 - 6.4	6¾ 171	9¼ 235	2 51	2	½ x 3 M12 x 76	80 110	100 150	4.5 2.0
5 125	5.563 141.3	300 20.7	7,292 32.44	0 - ¼ 0 - 6.4	6⅝ 175	9¼ 235	2 51	2	½ x 3 M12 x 76	80 110	100 150	4.6 2.1
6½ O.D. 165.1	6.500 165.1	300 20.7	9,955 44.28	0 - ¼ 0 - 6.4	7¾ 200	10¾ 264	2 51	2	½ x 3 M12 x 76	80 110	100 150	5.5 2.5
6 150	6.625 168.3	300 20.7	10,341 46.00	0 - ¼ 0 - 6.4	7⅞ 200	10¾ 264	2 51	2	½ x 3 M12 x 76	80 110	100 150	5.5 2.5
8 200	8.625 219.1	300 20.7	17,528 77.97	0 - ½ 0 - 3.2	10¼ 260	12¾ 324	2¾ 60	2	½ x 3 M12 x 76	80 110	100 150	8.4 3.8

For additional details see "Coupling Data Chart Notes" on page 264.

§ – For additional Bolt Torque information on page 202.

Not for use in copper systems.

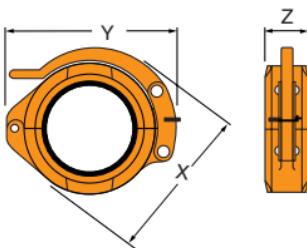
See Installation &amp; Assembly directions on pages 158-159.

Other sizes available, contact a Anvil Representative for more information.

# Couplings

**FIG. 7003**

HINGELOK® COUPLING



**SPECIAL NOTE:**

Fig. 7003 Hingelok Couplings are not designed for eccentric loading and therefore are not recommended for use at the end of concrete pumping booms or vertical risers above 30 feet (9.1 meters). Shockload must be considered and is to be included in the maximum working pressure listed above. Coupling keys, gasket cavity, and pipe grooves must be kept free of all foreign matter. Proper anchoring practice must always be exercised.

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Max. Wk. Pressure <i>PSI/bar</i>	Max. End Load <i>Lbs./kN</i>	Range of Pipe End Separation <i>In./mm</i>	Deflection from Ε Per Coupling		Coupling Dimensions			Approx. Wt. Ea. <i>Lbs./Kg</i>	
					Degrees	Per in./ft.	X <i>mm/m</i>	Y <i>in./mm</i>	Z <i>in./mm</i>		
1½ 40	1.900 48.3	300 20.7	851 3.78	0 - 1/8 0 - 3.2	3° 46'	0.79	3 5/8	4 1/4	1 7/8	1.7	
2 50	2.375 60.3	300 20.7	1,329 5.91	0 - 1/8 0 - 3.2	3° 1'	0.63	4 1/4	4 7/8	1 7/8	2.2	
2½ 65	2.875 73.0	300 20.7	1,948 8.66	0 - 1/8 0 - 3.2	2° 29'	0.52	5 1/4	5 7/8	1 7/8	3.2	
3 80	3.500 88.9	300 20.7	2,886 12.84	0 - 1/8 0 - 3.2	2° 3'	0.43	5 5/8	6 1/2	1 7/8	3.6	
4 100	4.500 114.3	300 20.7	4,771 21.22	0 - 1/4 0 - 6.4	3° 11'	0.67	7	7 3/4	2	5.1	
5 125	5.563 141.3	300 20.7	7,292 32.44	0 - 1/4 0 - 6.4	2° 35'	0.54	8 5/8	9 1/2	2 1/8	9.5	
6 150	6.625 168.3	300 20.7	10,341 46.00	0 - 1/4 0 - 6.4	2° 10'	0.45	9 7/8	10 7/8	2 1/8	11.2	
8 200	8.625 219.1	300 20.7	17,528 77.97	0 - 1/4 0 - 6.4	1° 40'	0.35	12	13 1/8	2 1/2	18.1	
							29.1	305	333	64	8.2

For additional details see "Coupling Data Chart Notes" on page 264.

Not for use in copper systems.

See Installation & Assembly directions on pages 160-161

**CAUTION:** Hammering or banging on the handle or coupling housing could cause serious damage to the locking device and coupling assembly. The result may be an unsuitable pipe joint and unusable coupling assembly. When re-using, always check for gasket damage, housing hinge and handle for looseness, distortion bent or any other damage.

**FIG. 7010**

REDUCING COUPLING

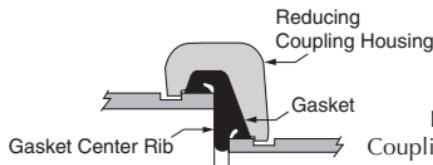
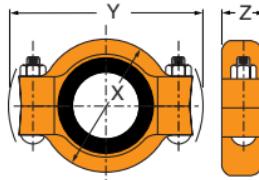
Fig. 7010  
Coupling with Gasket

FIGURE 7010 REDUCING COUPLING (CONTINUED ON NEXT PAGE)

Nominal Size	Larger O.D.	Smaller O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\epsilon$		Coupling Dimensions			Coupling Bolts		Specified		Approx. Wt. Ea.
						Per Coupling Degrees	Per in./ft.	X mm/m	Y in./mm	Z in./mm	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	In./mm	PSI/bar	Lbs./kN	In./mm										
2 x 1½	2.375	1.900	500	2,215	0 - ½	1° 53'	0.39	3⅝	5⅞	1⅓	2	½ x 2¾	80	100	2.0
50 x 40	60.3	48.3	34.5	9.85	0 - 3.2		32.9	92	149	48		M12 x 70	110	150	0.9
2½ x 2	2.875	2.375	500	3,246	0 - ½	1° 33'	0.32	4¼	6¾	1⅓	2	½ x 2¾	80	100	3.5
65 x 50	73.0	60.3	34.5	14.44	0 - 3.2		27.0	108	162	48		M12 x 70	110	150	1.6
3 x 2	3.500	2.375	500	4,811	0 - ½	1° 17'	0.27	4⅜	7⅛	1⅓	2	½ x 2¾	80	100	4.4
80 x 50	88.9	60.3	34.5	21.40	0 - 3.2		22.4	124	181	48		M12 x 70	110	150	2.0
3 x 2½	3.500	2.875	500	4,811	0 - ½	1° 17'	0.27	4⅜	7⅛	1⅓	2	½ x 2¾	80	100	4.1
80 x 65	88.9	73.0	34.5	21.40	0 - 3.2		22.4	124	181	48		M12 x 70	110	150	1.9
4 x 2	4.500	2.375	500	7,952	0 - ¾	2° 38'	0.55	6¼	8¾	2	2	½ x 3½	100	130	8.9
100 x 50	114.3	60.3	34.5	35.37	0 - 4.8		45.9	159	225	51		M16 x 85	135	175	4.0
4 x 2½	4.500	2.875	500	7,952	0 - ¾	2° 38'	0.55	6¼	8¾	2	2	½ x 3½	100	130	7.9
100 x 65	114.3	73.0	34.5	35.37	0 - 4.8		45.9	159	225	51		M16 x 85	135	175	3.6
4 x 3	4.500	3.500	500	7,952	0 - ¾	2° 38'	0.55	6¼	8¾	2	2	½ x 3½	100	130	6.7
100 x 80	114.3	88.9	34.5	35.37	0 - 4.8		45.9	159	225	51		M16 x 85	135	175	3.0

## Couplings

**FIG. 7010, CONT'D.**

REDUCING COUPLING

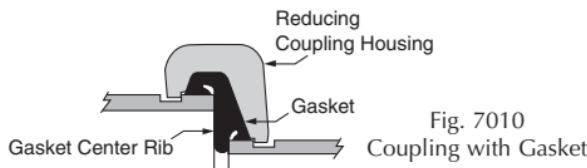
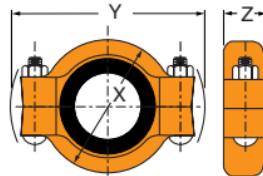


Fig. 7010  
Coupling with Gasket



**FIGURE 7010 REDUCING COUPLING (CONTINUED FROM PREVIOUS PAGE)**

Nominal Size	Larger O.D.	Smaller O.D.	Max. Working Pressure	Max. End Load	Range of Pipe End Separation	Deflection from $\epsilon$		Coupling Dimensions			Coupling Bolts		Specified Torque $\pm$		Approx. Wt. Ea.
						Per Coupling	Per in./ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	mm/m	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N·M	In./mm	Ft.-Lbs./N·M	Lbs./Kg
5 x 4	5.563	4.500	500	12,153	0 - 1/4	2° 5'	0.44	7 1/4	10 5/8	2 1/8	2	3/4 x 4 1/2	130	180	11.4
125 x 100	141.3	114.3	34.5	54.06	0 - 6.4		36.4	184	270	54		M20 x 110	175	245	5.2
6 x 4	6.625	4.500	500	17,236	0 - 1/4	1° 44'	0.36	8 1/4	11 5/8	2 1/8	2	3/4 x 4 1/2	130	180	13.4
150 x 100	168.3	114.3	34.5	76.67	0 - 6.4		30.2	210	295	54		M20 x 110	175	245	6.1
6 x 5	6.625	5.562	500	17,236	0 - 1/4	1° 44'	0.36	8 1/2	11 5/8	2 1/8	2	3/4 x 4 1/2	130	180	13.5
150 x 125	168.3	141.3	34.5	76.67	0 - 6.4		30.2	216	295	54		M20 x 110	175	245	6.1
8 x 6	8.625	6.625	500	29,213	0 - 1/4	1° 15'	0.26	10 1/2	14	2 1/4	2	3/4 x 4 1/2	130	180	17.7
200 x 150	219.1	168.3	34.5	129.95	0 - 6.4		21.8	267	356	57		M20 x 110	175	245	8.0

For additional details see "Coupling Data Chart Notes" on page 264.

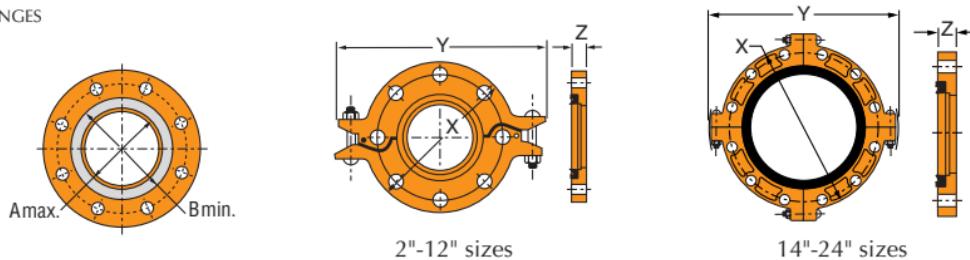
§ – For additional Bolt Torque information on page 202.

Not for use in copper systems.

See Installation & Assembly directions on pages 162-163.

FIG. 7012

GRUVLOK FLANGES



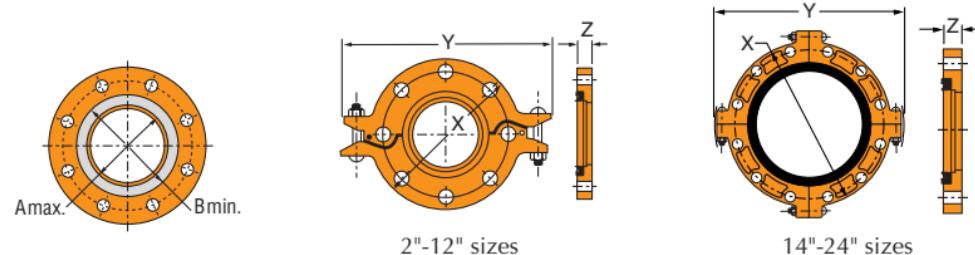
GRUVLOK FIGURE 7012 FLANGE: (CONTINUED ON NEXT PAGE)

Nominal Size	O.D.	Max. Working Pressure▼	Max. End Load▼	Latch Bolt		Dimensions			Sealing Surface		Mating Flange Bolts				Approx. Wt. Ea.	
				Latch* Bolt Size	Specified Torque §						Qty. ANSI	Size (ANSI)	in. (ISO) mm	Ft.-Lbs/N-M	Lbs./Kg	
				In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Ft.-Lbs/N-M	In./mm	In./mm	In./mm	In./mm	In./mm	PN10 (16)	
2	2.375	300	1,329	3/8 x 2 3/4	30	45	6 1/4	8 5/8	3/4	23 5/8	3 7/16	4	5/8 x 2 3/4	110	140	4.2
50	60.3	20.7	5.91	M10 x 70	40	60	159	213	19	60	87	4	M16 x 70	149	190	1.9
2 1/2	2.875	300	1,948	3/8 x 2 3/4	30	45	7	9 1/2	3/4	27 7/8	4	4	5/8 x 2 3/4	110	140	4.6
65	73.0	20.7	8.66	M10 x 70	40	60	178	241	19	73	102	-	M16 x 70	149	190	2.1
3 O.D.	2.996	300	2,115	-	30	45	7 1/4	9 3/4	3/4	3	4 1/8	-	-	110	140	4.8
76.1	76.1	20.7	9.41	M10 x 70	40	60	184	248	19	76	105	4	M16 x 70	149	190	2.2
3	3.500	300	2,886	3/8 x 2 3/4	30	45	7 7/8	10 1/2	3/4	3 1/2	4 9/16	4	5/8 x 2 3/4	110	140	6.0
88.9	88.9	20.7	12.84	M10 x 70	40	60	200	267	19	89	116	8	M16 x 70	149	190	2.7
4	4.500	300	4,771	3/8 x 2 3/4	30	45	9	11 1/2	3/4	4 1/2	5 5/16	8	5/8 x 2 3/4	110	140	6.3
100	114.3	20.7	21.22	M10 x 70	40	60	229	292	19	114	141	8	M16 x 70	149	190	2.9
5 1/2 O.D.	5.500	300	7,127	-	30	45	9 7/8	12 7/8	7/8	5 9/16	6 3/4	-	-	220	250	15.6
139.7	139.7	20.7	31.70	M10 x 70	40	60	251	327	22	141	171	8	M16 x 75	298	339	7.1

# Couplings

**FIG. 7012, CONT'D**

GRUVLOK FLANGES



GRUVLOK FIGURE 7012 FLANGE: (CONTINUED FROM PREVIOUS PAGE)

Nominal Size	O.D.	Max. Working Pressure	Max. End Load	Latch Bolt		Dimensions			Sealing Surface		Mating Flange Bolts			Approx. Wt. Ea.		
				Latch* Bolt Size	Specified Torque §						Min.	Max.	X	Y	Z	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Ft.-Lbs/N·M	In./mm	In./mm	In./mm	In./mm	In./mm	PN10 (16)	in. (ISO) mm	Ft.-Lbs/N·M	Lbs./Kg		
5	5.563	300	7,292	3/8 x 2 3/4	30	45	10	12 1/2	7/8	5 1/16	6 3/4	8	3/4 x 2 7/8	220	250	8.8
125	141.3	20.7	32.44	M10 x 70	40	60	254	318	22	141	171	-	-	298	339	4.0
6 1/2 O.D.	6.500	300	9,955	-	30	45	11 1/4	14	7/8	6 9/16	7 13/16	-	-	220	250	9.7
165.1	165.1	20.7	44.28	M10 x 70	40	60	286	356	22	168	198	8	M20 x 80	298	339	4.4
6	6.625	300	10,341	3/8 x 2 3/4	30	45	11	14	7/8	6 5/8	7 13/16	8	3/4 x 3 1/8	220	250	9.6
150	168.3	20.7	46.00	M10 x 70	40	60	279	356	22	168	198	8	M20 x 80	298	339	4.4
8	8.625	300	17,528	3/8 x 2 3/4	30	45	13 1/2	16 1/2	1	8 5/8	10	8	3/4 x 3 1/4	220	250	15.6
200	219.1	20.7	77.97	M10 x 70	40	60	343	419	25	219	254	8 (12)	M20 x 80	298	339	7.1
10	10.750	300	27,229	3/8 x 2 3/4	30	45	16	19	1	10 3/4	12 1/8	12	7/8 x 3 1/2	320	400	18.2
250	273.1	20.7	121.12	M10 x 70	40	60	406	483	25	273	308	12	M20 x 90	439	542	8.3
12	12.750	300	38,303	3/8 x 2 3/4	30	45	19	21 1/4	1 1/4	12 3/4	14 1/8	12	7/8 x 3 3/4	320	400	29.9
300	323.9	20.7	170.38	M10 x 70	40	60	483	552	32	324	359	12	-	439	542	13.6

FIG. 7012, CONT'D.

## GRUVLOK FLANGES

## GRUVLOK FIGURE 7012 FLANGE: (CONTINUED FROM PREVIOUS PAGE).

Nominal Size	O.D.	Max. Working Pressure▼	Max. End Load▼	Latch Bolt		Dimensions			Sealing Surface		Mating Flange Bolts				Approx. Wt. Ea.	
				Latch* Bolt Size	Specified Torque §						Mating Flange Bolts	Specified Torque §				
				Min.	Max.	X	Y	Z	A Max.	B Min.	Qty. ANSI	Size (ANSI)	Min.	Max.		
In./Dn(mm)	In./mm	PSI/kN	Lbs./kN	In./mm	Ft.-Lbs/N·M	In./mm	In./mm	In./mm	In./mm	In./mm	PN10 (16)	in. (ISO) mm	Ft.-Lbs/N·M	Lbs./Kg		
12 (PN) 300	12.750 323.9	300 20.7	38,303 170.38	- M10 x 70	40 30	60 45	18½ 460	21¼ 540	1 25	12¾ 324	14½ 359	12 12	- M20 x 90 +	320 439	400 542	20.9 9.5
14 350	14.000 355.6	300 20.7	46,181 205.43	5/8 x 4 1/4 -	100 136	130 176	21 533	24 610	1 1/2 38	14 356	16 406	12 -	1 x 4 1/4 -	360 488	520 705	52.5 23.8
16 400	16.000 406.4	300 20.7	60,319 268.31	5/8 x 4 1/4 -	100 136	130 176	23 1/2 597	26 1/2 673	1 1/2 38	16 406	18 457	16 -	1 x 4 1/4 -	360 488	520 705	67.0 30.4
18 450	18.000 457.2	300 20.7	76,341 339.58	3/4 x 5 -	130 176	180 244	25 635	29 737	1 5/8 41	18 457	20 508	16 -	1 1/8 x 4 3/4 -	450 610	725 983	82.5 37.4
20 500	20.000 508.0	300 20.7	94,248 419.23	3/4 x 5 -	130 176	180 244	27 1/2 699	31 1/2 800	1 3/4 44	20 508	22 559	20 -	1 1/8 x 4 3/4 -	450 610	725 983	106.5 48.3
24 600	24.000 609.6	250 17.2	113,097 503.08	7/8 x 5 1/2 -	180 244	220 298	32 813	36 1/2 927	1 7/8 48	24 610	26 660	20 -	1 1/4 x 5 1/2 -	620 841	1,000 1,356	138.5 62.8

+ PN 16 uses M24 x 90 (PN) Dimensions for bolt circle PN 10 &amp; 16 Flange.

\* Available in ANSI or metric bolt sizes only as indicated.

▼ Based on use with standard wall pipe.

§ – For additional Bolt Torque information, see page 202

The Gruvlok Flange bolt hole pattern conforms to ANSI Class 150 &amp; Class 125 flanges.

To avoid interference issues, flanges cannot be assembled directly to Series 7700

butterfly valve. Flange can be assembled to one side of series 7500 and 7600 valve only.

Mating flange bolts must be at least Intermediate Strength Bolting per ASME B16.5. Bolts with material properties equal or greater than SAE J429 Grade 5 are acceptable. Refer to Gruvlok Products Catalog or Anvil's web site for more information on installing this flange.

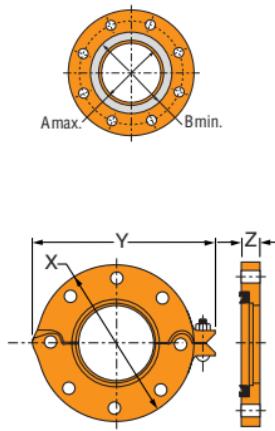
See Installation &amp; Assembly directions on pages 164-169.

For additional details see "Coupling Data Chart notes" on page 264.

# Couplings

**FIG. 7013**

GRUVLOK FLANGES  
(#300 FLANGE)



Nominal Size	O.D.	Max. Wk. Pressure	Max. End Load	Latch* Bolt Size	Specified Torque $\frac{ft \cdot lb}{N \cdot m}$		Dimensions			Sealing Surface		Mating Flange Bolts		Approx. Wt. Ea.	
					Min.	Max.	X	Y	Z	A Max.	B Min.	Qty. ANSI	Size (ANSI) in.	(ISO) mm	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In.	Fl.-Lbs/N-M	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Qty. ANSI	Size (ANSI) in.	(ISO) mm	Lbs./Kg
2	2.375	750	3,323	3/8 x 2 1/2	30	45	6 1/2	8	1	2 3/8	3 7/16	8	5/8 x 3	5.0	
50	60.3	51.7	14.78	-			165	203	25	60	87	-	-	2.3	
2 1/2	2.875	750	4,869	3/8 x 2 1/2	30	45	7 1/2	9 1/8	1	2 7/8	4	8	3/4 x 3 1/4	6.9	
65	73.0	51.7	21.66	-			191	232	25	73	102	-	-	3.1	
3	3.500	750	7,216	3/8 x 2 1/2	30	45	8 1/4	9 7/8	1 1/8	3 1/2	4 9/16	8	3/4 x 3 1/2	9.4	
80	88.9	51.7	32.10	-			210	251	29	89	116	-	-	4.3	
4	4.500	750	11,928	3/8 x 2 1/2	30	45	10	11 1/8	1 1/4	4 1/2	5 5/8	8	3/4 x 3 3/4	14.4	
100	114.3	51.7	53.06	-			254	289	32	114	143	-	-	6.5	
5	5.563	750	18,229	3/8 x 2 1/2	30	45	11	12 5/8	1 3/8	5 9/16	6 3/4	8	3/4 x 4 1/2	18.3	
125	141.3	51.7	81.09	-			279	321	35	141	171	-	-	8.3	
6	6.625	750	25,854	3/8 x 2 1/2	30	45	12 1/2	14 1/8	1 1/2	6 5/8	7 13/16	12	3/4 x 4 1/2	24.9	
150	168.3	51.7	115.00	-			318	359	38	168	198	-	-	11.3	
8	8.625	750	43,820	1 1/2 x 3 1/2	80	100	15	16 7/8	1 5/8	8 5/8	10	12	7/8 x 4 3/4	35.4	
200	219.1	51.7	194.92	-			381	429	41	219	254	-	-	16.1	
10	10.750	750	68,072	1 1/2 x 3 1/2	80	100	17 1/2	19 3/8	1 7/8	10 3/4	12 1/8	16	1 x 5	54.0	
250	273.1	51.7	302.80	-			445	492	48	273	308	-	-	24.5	
12	12.750	750	95,757	1 1/2 x 3 1/2	80	100	20 1/2	22 1/2	2	12 3/4	14 3/16	16	1 1/8 x 5 3/4	74.8	
300	323.9	51.7	425.95	-			521	572	51	324	360	-	-	33.9	

\* Available in ANSI or metric bolt sizes only as indicated.

Effective sealing area of mating flange must be free from gouges, undulations or deformities of any type to ensure proper sealing of the gasket.

Not for use with copper systems.

▼ Based on use with standard wall pipe.

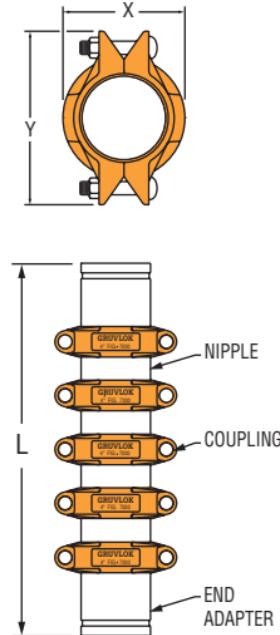
Flange cannot be assembled directly to Series 7700 butterfly valve. Flange can be assembled to one side of series 7500 & 7600 valve.

For Bolt Torque information, see page 202

For additional details see "Coupling Data Chart notes" on page 264.

**FIG. 7240**

EXPANSION JOINTS

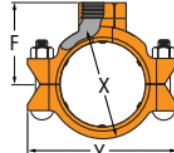
**7240 PERFORMANCE DATA**

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Coupling Figure	X <i>In./mm</i>	Y <i>In./mm</i>	Compressed Length L <i>In./mm</i>	Expanded Length L <i>In./mm</i>	Coupling Movement Capability <i>In./mm</i>	Number of Couplings	Total Movement Capability <i>In./mm</i>
2 50	2.375 60.3	7000	3½ 89	5½ 125	30 450	31½ 794	⅛ 3.2	10	1¼ 31.8
2½ 65	2.875 73.0	7000	4 100	5¾ 146	30 450	31½ 794	⅛ 3.2	10	1¼ 31.8
3 80	3.500 88.9	7000	4⅜ 117	6¾ 171	30 450	31½ 794	⅛ 3.2	10	1¼ 31.8
4 100	4.500 114.3	7000	5⅛ 149	8⅓ 206	17½ 445	18¾ 476	¼ 6.4	5	1¼ 31.8
5 125	5.562 141.3	7000	7 178	9½ 244	19 483	20¼ 514	¼ 6.4	5	1¼ 31.8
6 150	6.625 168.3	7000	8 200	11 279	19 483	20¼ 514	¼ 6.4	5	1¼ 31.8
8 200	8.625 219.0	7000	10⅔ 264	13¾ 337	22½ 572	23¾ 603	¼ 6.4	5	1¼ 31.8
10 250	10.750 273.1	7001	12⅞ 327	17½ 445	23½ 597	24¾ 629	¼ 6.4	5	1¼ 31.8
12 300	12.750 323.9	7001	15 381	19½ 495	23½ 597	24¾ 629	¼ 6.4	5	1¼ 31.8

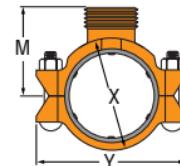
## Branch Outlets

FIG. 7042

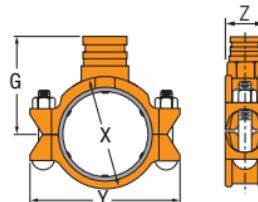
OUTLET COUPLING



Female IPS Outlet- 7042F



Male IPS Outlet - 7042M



Grooved Outlet - 7042G

FIGURE 7042 - OUTLET COUPLING (CONTINUED ON NEXT PAGE)

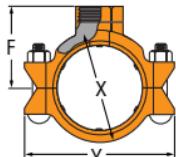
Run	Nominal Pipe Size		Working Pressure	Max. Run End Load	Range of Pipe End Separation	Coupling Dimensions						Bolt Size	Approx. Wt. Each			
	Outlet					X	Y	Z	FPT F	MPT M	Grv. G					
	FPT F	MPT/Grv. M/G				In./mm	In./mm	In./mm	In./mm	In./mm	In./mm					
In./DN(mm)	In./mm	In./mm	psi/bar	Lbs./kN	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg			
1½	½	—	500	1418	¾-1⅓	2¹⁵₁₆	4³⁴	2³⁴	2¹¹₁₆	2½	—	¾ x 2⅓	2.6			
	15	—	34.5	6.31	19-27	75	121	70	52	64	—	—	1.2			
	¾	—	500	1418	¾-1⅓	2¹⁵₁₆	4³⁴	2³⁴	2¹¹₁₆	2½	—	¾ x 2⅓	2.6			
	40	—	34.5	6.31	19-27	75	121	70	52	64	—	—	1.2			
	1	—	500	1418	¾-1⅓	2¹⁵₁₆	4³⁴	2³⁴	1¹⁵₁₆	2½	—	¾ x 2⅓	2.6			
	25	—	34.5	6.31	19-27	75	121	70	49	64	—	—	1.2			
2	½	—	500	2215	1¹¹₁₆-1	3⁷₁₆	5¹⁴	2³⁴	2⁹₁₆	2½	—	¾ x 2⅓	3.3			
	15	—	34.5	9.85	17-25	87	133	70	59	73	—	—	1.5			
	¾	—	500	2215	1¹¹₁₆-1	3⁷₁₆	5¹⁴	2³⁴	2⁹₁₆	2½	—	¾ x 2⅓	3.3			
	50	—	34.5	9.85	17-25	87	133	70	59	73	—	—	1.5			
	20	—	500	2215	1¹¹₁₆-1	3⁷₁₆	5¹⁴	2³⁴	2⁹₁₆	2½	3½	¾ x 2⅓	3.3			
	25	25	34.5	9.85	17-25	87	133	70	56	73	89	—	1.5			
2½	½	—	500	3246	1³¹⁶-1½	4³¹₆	6½	3¼	2⁹₁₆	3½	—	½ x 2⅓	4.8			
	15	—	34.5	14.44	30-38	106	165	83	65	79	—	—	2.2			
	¾	—	500	3246	1³¹⁶-1½	4³¹₆	6½	3¼	2⁹₁₆	3½	—	½ x 2⅓	4.8			
	20	—	34.5	14.44	30-38	106	165	83	65	79	—	—	2.2			
	1	—	500	3246	1³¹⁶-1½	4³¹₆	6½	3¼	2⁹₁₆	3½	—	½ x 2⅓	4.8			
	25	—	34.5	14.44	30-38	106	165	83	62	79	—	—	2.2			
	—	1¼	500	3246	1³¹⁶-1½	4³¹₆	6½	3¼	—	—	3⁷₈	½ x 2⅓	5.5			
	—	32	34.5	14.44	30-38	106	165	83	—	—	92	—	2.5			

See Installation &amp; Assembly directions on pages 170-171.

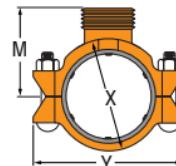
For additional details see "Coupling Data Chart notes" on page 264.

FIG. 7042, CONT'D.

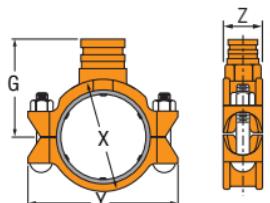
## OUTLET COUPLING



Female IPS Outlet- 7042F



Male IPS Outlet - 7042M



Grooved Outlet - 7042G

FIGURE 7042 - OUTLET COUPLING (CONTINUED FROM PREVIOUS PAGE).

Run	Nominal Pipe Size		Working Pressure	Max. Run End Load	Range of Pipe End Separation	Coupling Dimensions						Bolt Size	Approx. Wt. Each
	Outlet	FPT F	MPT/Grv. M/G			X	Y	Z	FPT F	MPT M	Grv. G		
In./DN(mm)	In./mm	In./mm	psi/bar	Lbs./kN	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
3 80	3/4	—	500	4811	1 1/16-1 1/2	4 3/4	7 1/4	3 1/4	2 13/16	3 3/8	—	1/2 x 3	7.9
	20	—	34.5	21.40	30-38	121	184	83	72	86	—	—	3.6
	1	1	500	4811	1 1/16-1 1/2	4 3/4	7 1/4	3 1/4	2 3/4	3 3/8	4	1/2 x 3	7.9
	25	25	34.5	21.40	30-38	121	184	83	70	86	102	—	3.6
	—	1 1/2	500	4811	1 1/16-1 1/2	4 3/4	7 1/4	3 1/4	—	—	4	1/2 x 3	8.6
	—	40	34.5	21.40	30-38	121	184	83	—	—	102	—	3.9
4 100	3/4	—	500	7952	1 1/16-1 1/2	6 3/16	8 1/8	3 5/8	3 11/16	4 1/4	—	5/8 x 3 1/2	9.9
	20	—	34.5	35.37	40-48	157	225	92	94	108	—	—	4.5
	1	—	500	7952	1 1/16-1 1/2	6 3/16	8 1/8	3 5/8	3 9/16	4 1/4	—	5/8 x 3 1/2	9.9
	25	—	34.5	35.37	40-48	157	225	92	91	108	—	—	4.5
	—	1 1/2	500	7952	1 1/16-1 1/2	6 3/16	8 1/8	3 5/8	—	—	4 7/8	5/8 x 3 1/2	11.0
	—	40	34.5	35.37	40-48	157	225	92	—	—	124	—	5.0
6 150	—	2	500	7952	1 1/16-1 1/2	6 3/16	8 1/8	3 5/8	—	—	4 7/8	5/8 x 3 1/2	11.0
	—	50	34.5	35.37	40-48	157	225	92	—	—	124	—	5.0
	1	—	500	17236	1 5/8-1 15/16	8 1/8	11 1/4	3 3/4	4 3/4	5 3/8	—	5/8 x 3 1/2	18.0
	25	—	34.5	76.66	41-51	206	286	95	121	137	—	—	8.2
	1 1/2	1 1/2	500	17236	1 5/8-1 15/16	8 1/8	11 1/4	3 3/4	4 3/4	5 3/8	6	5/8 x 3 1/2	18.0
	40	40	34.5	76.66	41-51	206	286	95	121	137	152	—	8.2
—	2	500	17236	1 5/8-1 15/16	8 1/8	11 1/4	3 3/4	—	—	6	5/8 x 3 1/2	18.7	—
	—	50	34.5	76.66	41-51	206	286	95	—	—	152	—	8.5

Pipe ends must be prepared in accordance with Gruvlok "Roll or Cut Groove Specifications for Steel & Other IPS or ISO size Pipe". Pressure & end load ratings are for use with standard wall steel pipe.

For a one-time field test only, the maximum working pressure may be increased 1 1/2 times the figure shown.  
Not for use in copper systems.

## Branch Outlets

**FIG. 7045**

CLAMP-T, FPT BRANCH

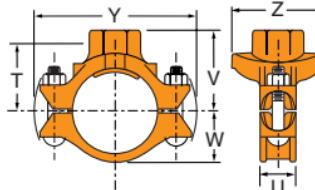


Fig. 7045

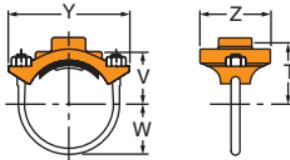


Fig. 7045 (U-Bolt)

**FIGURE 7045-FPT BRANCH (CONTINUED ON NEXT PAGE)**

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure▼	Clamp-T Dimensions						Bolt Size	Specified Torque \$		Approx. Wt. Each		
		Min. Dia.	Max. Dia.		T	U	V Threaded	W	Y	Z		In./mm	In./mm	In./mm		
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N-M	Lbs./Kg
2 x 1½ 50 x 15	2.375 x 0.840 60.3 x 21.3	1½ 38	1⅝ 41	500 34.5	2⅜/16 56	9/16 14	2⅖/16 67	1/2 12	5½ 140	3 76	1/2 U-Bolt	30	40	2.3 1.0		
2 x ¾ 50 x 20	2.375 x 1.050 60.3 x 26.7	1½ 38	1⅝ 41	500 34.5	2⅓/16 52	9/16 14	2⅖/16 67	1½ 38	5½ 140	3 76	1/2 U-Bolt	30	40	2.3 1.0		
2 x 1 50 x 25	2.375 x 1.315 60.3 x 33.7	1½ 38	1⅝ 41	500 34.5	1⅛/16 51	9/16 14	2⅖/16 67	1½ 38	5½ 140	3 76	1/2 U-Bolt	30	40	2.6 1.2		
2 x 1¼ 50 x 32	2.375 x 1.660 60.3 x 42.4	2 51	2⅛ 54	500 34.5	2⅔/16 55	9/16 14	2⅖/16 73	1½ 38	5½ 140	3½ 89	1/2 U-Bolt	30	40	2.7 1.2		
2 x 1½ 50 x 40	2.375 x 1.900 60.3 x 48.3	2 51	2⅛ 54	500 34.5	2⅔/16 55	9/16 14	2⅖/16 73	1½ 38	7 178	3½ 89	1/2 U-Bolt	30	40	2.5 1.1		
2½ x ½ 65 x 15	2.875 x 0.840 73.0 x 21.3	1½ 38	1⅝ 41	500 34.5	2⅗/16 62	9/16 14	2⅖/16 73	1¾ 44	5½ 140	3 76	1/2 U-Bolt	30	40	3.0 1.4		
2½ x ¾ 65 x 20	2.875 x 1.050 73.0 x 26.7	1½ 38	1⅝ 41	500 34.5	2⅔/16 59	9/16 14	2⅖/16 73	1¾ 44	5½ 140	3 76	1/2 U-Bolt	30	40	2.9 1.3		
2½ x 1 65 x 25	2.875 x 1.315 73.0 x 33.7	1½ 38	1⅝ 41	500 34.5	2⅔/16 55	9/16 14	2⅖/16 73	1¾ 44	6⅓ 156	3 76	1/2 U-Bolt	30	40	2.9 1.3		
2½ x 1¼ 65 x 32	2.875 x 1.660 73.0 x 42.4	2 51	2⅛ 54	500 34.5	2⅗/16 62	9/16 14	3⅓/16 79	1¾ 44	6⅓ 156	3½ 86	1/2 U-Bolt	30	40	3.4 1.5		

## FIG. 7045, CONT'D.

CLAMP-T, FPT BRANCH

FIGURE 7045-FPT BRANCH (CONTINUED FROM PREVIOUS PAGE)

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Hole Dimensions		Max. Working Pressure ▼ <i>psi/bar</i>	Clamp-T Dimensions						Bolt Size <i>In./mm</i>	Specified Torque §		Approx. Wt. Each <i>Lbs./Kg</i>
		Min. Dia. <i>In./mm</i>	Max. Dia. <i>In./mm</i>		T <i>In./mm</i>	U <i>In./mm</i>	V Threaded <i>In./mm</i>	W <i>In./mm</i>	Y <i>In./mm</i>	Z <i>In./mm</i>		Ft.-Lbs./N-M	Min. Max.	
2½ x 1½ <i>65 x 40</i>	2.875 x 1.900 <i>73.0 x 48.3</i>	2 <i>51</i>	2⅛ <i>54</i>	500 <i>34.5</i>	2⅞ <i>62</i>	9/16 <i>14</i>	3⅓ <i>79</i>	1¾ <i>44</i>	6⅓ <i>156</i>	3⅜ <i>86</i>	½ U-Bolt	30 -	40	3.4 1.5
3 x 1½ <i>80 x 15</i>	3.500 x 0.840 <i>88.9 x 21.3</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	2⅔ <i>65</i>	9/16 <i>14</i>	3 <i>76</i>	2⅛ <i>54</i>	7 <i>178</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.8 1.2
3 x ¾ <i>80 x 20</i>	3.500 x 1.050 <i>88.9 x 26.7</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	2⅗ <i>62</i>	9/16 <i>14</i>	3 <i>76</i>	2⅛ <i>54</i>	7 <i>178</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.7 1.2
3 x 1 <i>80 x 25</i>	3.500 x 1.315 <i>88.9 x 33.7</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	2⅘ <i>59</i>	9/16 <i>14</i>	3 <i>76</i>	2⅛ <i>54</i>	7 <i>178</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.7 1.2
3 x 1¼ <i>80 x 32</i>	3.500 x 1.660 <i>88.9 x 42.4</i>	2 <i>51</i>	2⅛ <i>54</i>	500 <i>34.5</i>	2⅙ <i>68</i>	1½ <i>38</i>	3⅓ <i>86</i>	2⅛ <i>54</i>	6⅓ <i>175</i>	3⅔ <i>95</i>	½ x 2¾	80	100	3.4 1.5
3 x 1½ <i>80 x 40</i>	3.500 x 1.900 <i>88.9 x 48.3</i>	2 <i>51</i>	2⅛ <i>54</i>	500 <i>34.5</i>	2⅙ <i>68</i>	1½ <i>38</i>	3⅓ <i>86</i>	2⅛ <i>54</i>	6⅓ <i>175</i>	3⅔ <i>95</i>	½ x 2¾	80	100	4.4 2.0
3 x 2 <i>80 x 50</i>	3.500 x 2.375 <i>88.9 x 60.3</i>	2½ <i>64</i>	2⅝ <i>67</i>	500 <i>34.5</i>	2⅙ <i>68</i>	1½ <i>38</i>	3⅓ <i>86</i>	2⅛ <i>54</i>	6⅓ <i>175</i>	4⅛ <i>105</i>	½ x 2¾	80	100	4.6 2.1
4 x ½ <i>100 x 15</i>	4.500 x 0.840 <i>114.3 x 21.3</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	3⅓ <i>76</i>	9/16 <i>14</i>	3½ <i>89</i>	2½ <i>67</i>	7¾ <i>197</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.9 1.3
4 x ¾ <i>100 x 20</i>	4.500 x 1.050 <i>114.3 x 26.7</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	3⅓ <i>78</i>	9/16 <i>14</i>	3½ <i>89</i>	2½ <i>67</i>	7¾ <i>197</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.8 1.3
4 x 1 <i>100 x 25</i>	4.500 x 1.315 <i>114.3 x 33.7</i>	1½ <i>38</i>	1⅝ <i>41</i>	500 <i>34.5</i>	2⅓ <i>73</i>	9/16 <i>14</i>	3½ <i>89</i>	2½ <i>67</i>	7¾ <i>197</i>	3⅔ <i>95</i>	½ U-Bolt	30 -	40	2.7 1.2

**NOTE:** 2½", 5" and 6" Nom. size run pipe may be used on 3" O.D., 5½" O.D. and 6½" O.D. pipe

▼ Based on use with standard wall pipe.

Not for use in copper systems.

## Branch Outlets

**FIG. 7045, CONT'D.**

CLAMP-T, FPT BRANCH

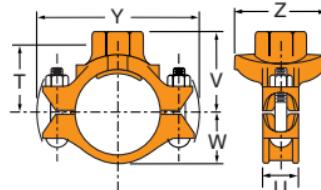


Fig. 7045

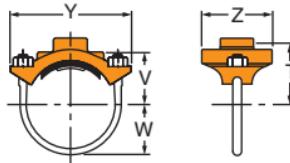


Fig. 7045 (U-Bolt)

**FIGURE 7045-FPT BRANCH (CONTINUED ON NEXT PAGE)**

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure ▼	Clamp-T Dimensions						Bolt Size	Specified Torque \$		Approx. Wt. Each
		Min. Dia.	Max. Dia.		T	U	V Threaded	W	Y	Z		In./mm	Ft.-Lbs./N-M	Lbs./Kg
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm
4 x 1¼ 100 x 32	4.500 x 1.660 114.3 x 42.4	2	2½	500 34.5	3½ 81	1¾ 48	3½ 98	2½ 67	7½ 191	3¾ 95	½ x 2¾	80	100	4.5 2.0
4 x 1½ 100 x 40	4.500 x 1.900 114.3 x 48.3	2	2½	500 34.5	3½ 81	1¾ 48	3½ 98	2½ 67	7½ 191	3¾ 95	½ x 2¾	80	100	4.6 2.1
4 x 2 100 x 50	4.500 x 2.375 114.3 x 60.3	2½	2½	500 34.5	3½ 84	1¾ 48	102	2½ 67	7½ 191	4½ 105	½ x 2¾	80	100	7.7 3.5
4 x 2½ 100 x 65	4.500 x 2.875 114.3 x 73.0	2¾	2¾	500 34.5	3½ 78	1¾ 48	102	2½ 67	7½ 191	4¾ 111	½ x 2¾	80	100	5.2 2.4
4 x 3 O.D. 114.3 x 76.1	4.500 x 2.996 114.3 x 76.1	2¾	2¾	500 34.5	3 76	1¾ 48	102	2½ 67	7½ 191	4¾ 111	½ x 2¾	80	100	5.2 2.4
4 x 3 100 x 80	4.500 x 3.500 114.3 x 88.9	3½	3½	500 34.5	3½ 83	1¾ 48	108	2½ 67	7½ 191	5¼ 133	½ x 3½	80	100	6.5 2.9
5 x 1¼ 125 x 32	5.563 x 1.660 141.3 x 42.4	2	2½	500 34.5	3⅓ 94	1¾ 48	111	3½ 83	9½ 232	3¾ 95	½ x 3½	100	130	5.4 2.4
5 x 1½ 125 x 40	5.563 x 1.900 141.3 x 48.3	2	2½	500 34.5	3⅓ 94	1¾ 48	111	3½ 83	9½ 232	3¾ 95	½ x 3½	100	130	5.5 2.5
5 x 2 125 x 50	5.563 x 2.375 141.3 x 60.3	2½	2½	500 34.5	3⅓ 97	1¾ 48	114	3½ 83	9½ 232	4½ 105	½ x 3½	100	130	5.7 2.6

## FIG. 7045, CONT'D.

CLAMP-T, FPT BRANCH

FIGURE 7045-FPT BRANCH (CONTINUED FROM PREVIOUS PAGE)

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure ▼	Clamp-T Dimensions						Bolt Size	Specified Torque \$		Approx. Wt. Each
		Min. Dia.	Max. Dia.		T	U	V Threaded	W	Y	Z		Min.	Max.	
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N·M	Lbs./Kg	
5 x 2½	5.563 x 2.875	2¾	2⅜	500	3¹³/₁₆	1⅓	4¾	3¼	9⅓	4¾	5/8 x 3¼	100	130	7.0
125 x 65	141.3 x 73.0	70	73	34.5	97	48	121	83	232	111	-			3.2
5 x 3 O.D.	5.563 x 2.996	2¾	2⅜	500	3¾	1⅓	4¾	3¼	9⅓	4¾	¾ x 4½	130	180	7.0
141.3 x 76.1	141.3 x 76.1	70	73	34.5	95	48	121	83	232	111	-			3.2
5 x 3	5.563 x 3.500	3½	3⅝	500	4	1⅓	5	3¼	9⅓	5¼	5/8 x 3¼	100	130	8.7
125 x 80	141.3 x 88.9	89	92	34.5	102	48	127	83	232	133	-			3.9
6 x 1¼	6.625 x 1.660	2	2⅛	500	4¾₁₆	2	4¾	3⅔	10⅓	3¾	5/8 x 4¼	100	130	7.8
150 x 32	168.3 x 42.4	51	54	34.5	106	51	124	98	257	95	-			3.5
6 x 1½	6.625 x 1.900	2	2⅛	500	4¾₁₆	2	4¾	3⅔	10⅓	3¾	5/8 x 4¼	100	130	7.8
150 x 40	168.3 x 48.3	51	54	34.5	106	51	124	98	257	95	-			3.5
6 x 2	6.625 x 2.375	2½	2⅚	500	4¾₁₆	2	4¾	3⅔	10⅓	4⅓	5/8 x 4¼	100	130	7.8
150 x 50	168.3 x 60.3	64	67	34.5	106	51	124	98	257	105	-			3.5
6 x 2½	6.625 x 2.875	2¾	2⅜	500	4¾₁₆	2	5⅓	3⅔	10⅓	4¾	5/8 x 4¼	100	130	8.4
150 x 65	168.3 x 73.0	70	73	34.5	106	51	130	98	257	111	-			3.8
6 x 3 O.D.	6.625 x 2.996	2¾	2⅜	500	4⅓	2	5⅓	3⅔	10⅓	4¾	5/8 x 4¼	100	130	8.4
168.3 x 76.1	168.3 x 76.1	70	73	34.5	105	51	130	98	257	111	-			3.8
6 x 3	6.625 x 3.500	3½	3⅝	500	4¾	2	5⅓	3⅔	10⅓	5¼	5/8 x 4¼	100	130	9.6
150 x 80	168.3 x 88.9	89	92	34.5	111	51	137	98	257	133	-			4.4
6 x 4	6.625 x 4.500	4½	4⅜	500	4¾	2	5½	3⅔	10⅓	6½	5/8 x 4¼	100	130	10.5
150 x 100	168.3 x 114.3	114	117	34.5	111	51	140	98	257	165	-			4.8

**NOTE:** 2½", 5" and 6" Nom. size run pipe may be used on 3" O.D., 5½" O.D. and 6½" O.D. pipe

▼ Based on use with standard wall pipe.

Not for use in copper systems.

GRUVLOK®

## Branch Outlets

**FIG. 7045, CONT'D.**

CLAMP-T, FPT BRANCH

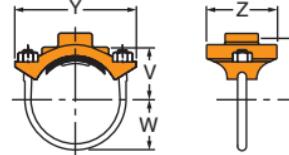
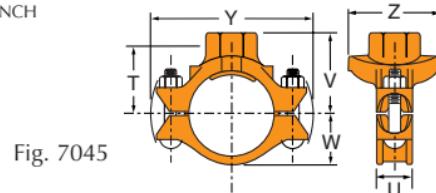


Fig. 7045 (U-Bolt)

**FIGURE 7045-FPT BRANCH (CONTINUED FROM PREVIOUS PAGE)**

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure▼	Clamp-T Dimensions						Bolt Size	Specified Torque §		Approx. Wt. Each	
		Min. Dia.	Max. Dia.		T	U	V Threaded	W	Y	Z		In./mm	In./mm	Ft.-Lbs./N-M	Lbs./Kg
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	
8 x 2	8.625 x 2.750	2½	2⁵/₈	500	5³/₁₆	2¼	5¹/₈	5	12³/₄	4¹/₂	⁵/₈ x 4¼	100	130	11.2	
200 x 50	219.1 x 70.0	64	67	34.5	132	57	149	127	324	105	-	-	-	5.1	
8 x 2½	8.625 x 2.875	2¾	2⁷/₈	500	5⁹/₁₆	2¼	6¹/₄	5	12³/₄	4³/₈	⁵/₈ x 4¼	100	130	11.1	
200 x 65	219.1 x 73.0	70	73	34.5	134	57	159	127	324	111	-	-	-	5.0	
8 x 3 O.D.	8.625 x 2.996	2¾	2⁷/₈	500	5³/₄	2¼	6¹/₄	5	12³/₄	4³/₈	⁵/₈ x 4¼	100	130	11.1	
219.1 x 76.1	219.1 x 76.1	70	73	34.5	133	57	159	127	324	111	-	-	-	5.0	
8 x 3	8.625 x 3.500	3½	3⁵/₈	500	5⁹/₈	2¼	6³/₈	5	12³/₄	5¹/₄	⁵/₈ x 4¼	100	130	13.0	
200 x 80	219.1 x 88.9	89	92	34.5	137	57	162	127	324	133	-	-	-	5.9	
8 x 4	8.625 x 4.500	4½	4⁵/₈	500	5³/₈	2¼	6¹/₂	5	12³/₄	6¹/₂	⁵/₈ x 4¼	100	130	16.2	
200 x 100	219.1 x 114.3	114	117	34.5	137	57	165	127	324	165	-	-	-	7.3	

**NOTE:** 2½", 5" and 6" Nom. size run pipe may be used on 3" O.D., 5½" O.D. and 6½" O.D. pipe

▼ Based on use with standard wall pipe.

Not for use in copper systems.

§ – For additional Bolt Torque information, see page 202.

See Installation & Assembly directions on pages 172-173.

**FIG. 7046**

CLAMP-T, GROOVED BRANCH

Fig. 7046

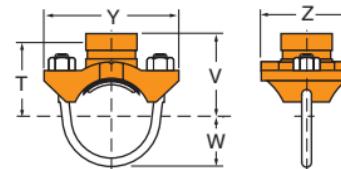
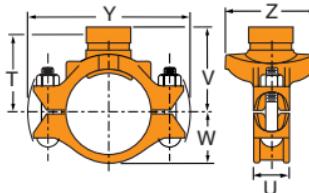


Fig. 7046 (U-BOLT)

FIGURE 7046-GR BRANCH (CONTINUED ON NEXT PAGE)

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure ▼	Clamp-T Dimensions					Bolt Size	Specified Torque §		Approx. Wt. Each	
		Min. Dia.	Max. Dia.		U	V Grooved	W	Y	Z		Min.	Max.		
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm			Fl.-Lbs./N·M	Lbs./Kg
2½ x 1¼*	2.875 x 1.660	2	2⅛	500	9/16	3⅓	1¾	6⅓	3½	1/2 U-Bolt	30	40	3.4	
65 x 32	73.0 x 42.4	51	54	34.5	14	79	44	156	89	-				1.5
2½ x 1½	2.875 x 1.900	2	2⅛	500	9/16	3⅓	1¾	6⅓	3½	1/2 U-Bolt	30	40	3.4	
65 x 40	73.0 x 48.3	51	54	34.5	14	79	44	156	89	-				1.5
3 x 1¼	3.500 x 1.660	2	2⅛	500	1½	3½	2⅓	6⅓	3¾	1/2 x 2¾	80	100	3.4	
80 x 32	88.9 x 42.4	51	54	34.5	38	89	54	175	95	-				1.5
3 x 1½	3.500 x 1.900	2	2⅛	500	1½	3½	2⅓	6⅓	3¾	1/2 x 2¾	80	100	4.4	
80 x 40	88.9 x 48.3	51	54	34.5	38	89	54	175	95	-				2.0
3 x 2	3.500 x 2.375	2½	2½	500	1½	3½	2⅓	6⅓	4⅓	1/2 x 2¾	80	100	4.6	
80 x 50	88.9 x 60.3	64	67	34.5	38	89	54	175	105	-				2.1
4 x 1¼	4.500 x 1.660	2	2⅛	500	1⅓	4	2⅓	7½	3¾	1/2 x 2¾	80	100	4.2	
100 x 32	114.3 x 42.4	51	54	34.5	48	102	67	191	95	-				1.9
4 x 1½	4.500 x 1.900	2	2⅛	500	1⅓	4	2⅓	7½	3¾	1/2 x 2¾	80	100	4.3	
100 x 40	114.3 x 48.3	51	54	34.5	48	102	67	191	95	-				2.0
4 x 2	4.500 x 2.375	2½	2½	500	1⅓	4	2⅓	7½	4⅓	1/2 x 2¾	80	100	4.6	
100 x 50	114.3 x 60.3	64	67	34.5	48	102	67	191	105	-				2.1

## Branch Outlets

**FIG. 7046, CONT'D.**

CLAMP-T, GROOVED BRANCH

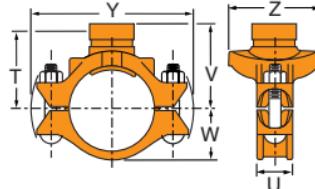


Fig. 7046

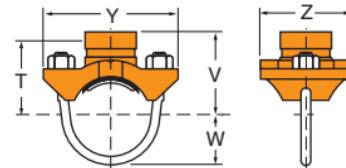


Fig. 7046 (U-BOLT)

**FIGURE 7046-GR BRANCH (CONTINUED ON NEXT PAGE)**

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure ▼	Clamp-T Dimensions					Bolt Size	Specified Torque §		Approx. Wt. Each
		Min. Dia.	Max. Dia.		U	V Grooved	W	Y	Z		Min.	Max.	
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N-M	Lbs./Kg	
4 x 2½ 100 x 65	4.500 x 2.875 114.3 x 73.0	2¾ 70	2⅜ 73	500 34.5	1⅛ 48	4 102	2⅝ 67	7½ 191	4⅔ 111	½ x 2¾	80 -	100 -	5.0 2.3
4 x 3 O.D. 114.3 x 76.1	4.500 x 2.996 114.3 x 76.1	2¾ 70	2⅜ 73	500 34.5	1⅛ 48	4 102	2⅝ 67	7½ 191	4⅔ 111	½ x 2¾	80 -	100 -	5.0 2.3
4 x 3 100 x 80	4.500 x 3.500 114.3 x 88.9	3½ 89	3⅜ 92	500 34.5	1⅛ 48	4 102	2⅝ 67	7½ 191	5¼ 133	½ x 3½	80 -	100 -	5.6 2.5
5 x 1¼ 125 x 32	5.563 x 1.660 141.3 x 42.4	2 51	2⅓ 54	500 34.5	1⅛ 48	4⅓ 108	3⅓ 83	9⅓ 232	3⅔ 95	½ x 2¾	80 -	100 -	5.6 2.5
5 x 1½ 125 x 40	5.563 x 1.900 141.3 x 48.3	2 51	2⅓ 54	500 34.5	1⅛ 48	4⅓ 108	3⅓ 83	9⅓ 232	3⅔ 95	½ x 3½	100 -	130 -	5.6 2.5
5 x 2 125 x 50	5.563 x 2.375 141.3 x 60.3	2½ 64	2⅔ 67	500 34.5	1⅛ 48	4⅔ 108	3⅔ 83	9⅔ 232	4⅕ 105	½ x 3½	100 -	130 -	5.5 2.5
5 x 2½ 125 x 65	5.563 x 2.875 141.3 x 73.0	2¾ 70	2⅜ 73	500 34.5	1⅛ 48	4⅔ 108	3⅔ 83	9⅔ 232	4⅖ 111	½ x 3½	100 -	130 -	5.8 2.6
5 x 3 125 x 80	5.563 x 3.500 141.3 x 88.9	3½ 89	3⅜ 92	500 34.5	1⅛ 48	4⅔ 117	3⅔ 83	9⅔ 232	5⅓ 133	½ x 3½	100 -	130 -	7.1 3.2

## FIG. 7046, CONT'D.

CLAMP-T, GROOVED BRANCH

FIGURE 7046-GR BRANCH (CONTINUED ON NEXT PAGE)

Nominal Size	O.D.	Hole Dimensions		Max. Working Pressure▼	Clamp-T Dimensions					Bolt Size	Specified Torque §		Approx. Wt. Each
		Min. Dia.	Max. Dia.		U	V Grooved	W	Y	Z		Min.	Max.	
In./DN(mm)	In./mm	In./mm	In./mm	psi/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs./N-M	Lbs./Kg	
6 x 1½	6.625 x 1.900	2	2½	500	2	5	3½	10½	3¾	5/8 x 4¼	100	130	7.2
150 x 40	168.3 x 48.3	51	54	34.5	51	127	98	257	95	*			3.3
6 x 2	6.625 x 2.375	2½	2¾	500	2	5	3½	10½	4½	5/8 x 4¼	100	130	7.8
150 x 50	168.3 x 60.3	64	67	34.5	51	127	98	257	105	*			3.5
6 x 2½	6.625 x 2.875	2¾	2½	500	2	5½	3½	10½	4¾	5/8 x 4¼	100	130	7.6
150 x 65	168.3 x 73.0	70	73	34.5	51	130	98	257	111	*			3.4
6 x 3 O.D.	6.625 x 2.996	2¾	2½	500	2	5½	3½	10½	4¾	5/8 x 4¼	100	130	7.6
168.3 x 76.1	168.3 x 76.1	70	73	34.5	51	130	98	257	111	*			3.4
6 x 3	6.625 x 3.500	3½	3½	500	2	5½	3½	10½	5¼	5/8 x 4¼	100	130	8.0
150 x 80	168.3 x 88.9	89	92	34.5	51	130	98	257	133	*			3.6
6 x 4	6.625 x 4.500	4½	4½	500	2	5¼	3½	10½	6½	5/8 x 4¼	100	130	10.4
150 x 100	168.3 x 114.3	114	117	34.5	51	133	98	257	165	*			4.7
8 x 2	8.625 x 2.375	2½	2¾	500	2¼	6½	5	12¾	4¼	¾ x 4½	130	180	10.4
200 x 50	219.1 x 60.3	64	67	34.5	57	156	127	324	108	-			4.7
8 x 2½	8.625 x 2.875	2¾	2½	500	2¼	6½	5	12¾	4¾	¾ x 4½	130	180	10.6
200 x 65	219.1 x 73.0	70	73	34.5	57	156	127	324	111	M20 x 110	175	245	4.8
8 x 3	8.625 x 3.500	3½	3½	500	2¼	6½	5	12¾	5¼	¾ x 4½	130	180	11.5
200 x 80	219.1 x 88.9	89	92	34.5	57	156	127	324	133	M20 x 110	175	245	5.2
8 x 4	8.625 x 4.500	4½	4½	500	2¼	6½	5	12¾	6½	¾ x 4½	130	180	16.2
200 x 100	219.1 x 114.3	114	117	34.5	57	159	127	324	165	M20 x 110	175	245	7.3

NOTE: 2½", 5" &amp; 6" Nom. size run pipe may be used on 3" O.D., 5½" O.D. &amp; 6½" O.D. pipe.

• Cannot be used in cross configuration.

▼ Based on use with standard wall pipe.

§ – For additional Bolt Torque information, see page 202.

Not for use in copper systems.

See Installation &amp; Assembly directions on pages 172-173.

## Branch Outlets

### FIG. 7047, FIG. 7048 & FIG. 7049

CLAMP-T, CROSS

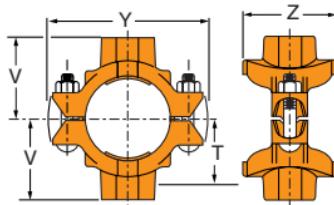


Fig. 7047 – Thread x Thread

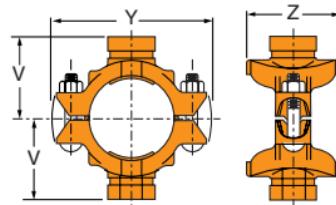


Fig. 7048 – Groove x Groove

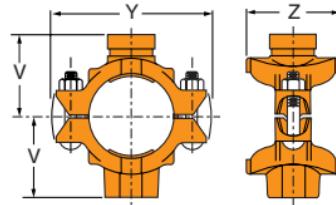


Fig. 7049 – Groove x Thread

The Gruvlok Clamp-T provides for a branch or cross connection in light wall or standard wall steel pipe.

The Fig. 7045 Clamp-T female pipe thread branch is available with NPT or ISO 7/1 connection and the Fig. 7046 Clamp-T has grooved-end branch connection.

Clamp-T cross connections are available allowing greater versatility in piping design.

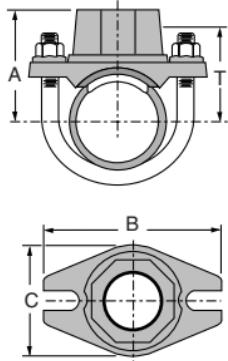
#### NOTES:

2 $\frac{1}{2}$ " x 1 $\frac{1}{4}$ " Figure 7046 cannot be used in cross configuration.

In addition, 2 x 1 $\frac{1}{2}$ " through 2 x 1 $\frac{1}{2}$ " can now be made into crosses from the new design.

FIG. 7044

## BRANCH OUTLET



Maximum Working Pressure for all sizes is 175 PSI (12.1 bar)

Not for use in copper systems.

§ – For additional Bolt Torque information on page 202

For additional details see "Coupling Data Chart notes" from page 264.

See Installation & Assembly directions on pages 174-175.

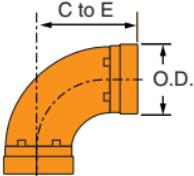
FIGURE 7044 BRANCH OUTLET

Nominal Size	O.D.	Hole Diameter		Dimensions			Take-out T	Specified Torque §		Approx. Wt. Each
		Min. Dia.	Max. Dia.	A	B	C		Min.	Max.	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm		Ft.-Lbs./N·M	Lbs./Kg	
1 1/4 x 1/2 32 x 15	1.660 x 0.840 42.4 x 21.3	1 3/16 30	1 1/4 32	2 1/16 53	3 1/2 89	2 7/32 56	1 3/8 35	27 33	0.8 0.4	
1 1/4 x 3/4 32 x 20	1.660 x 1.050 42.4 x 26.7	1 3/16 30	1 1/4 32	2 1/16 53	3 1/2 89	2 7/32 56	1 3/8 35	27 33	0.8 0.4	
1 1/4 x 1 32 x 25	1.660 x 1.315 42.4 x 33.7	1 3/16 30	1 1/4 32	2 9/16 56	3 1/2 89	2 7/32 56	1 1/2 38	27 33	0.9 0.4	
1 1/2 x 1/2 40 x 15	1.900 x 0.840 48.3 x 21.3	1 3/16 30	1 1/4 32	2 5/32 55	3 1/2 89	2 7/32 56	1 3/8 35	27 33	0.8 0.4	
1 1/2 x 3/4 40 x 20	1.900 x 1.050 48.3 x 26.7	1 3/16 30	1 1/4 32	2 5/32 55	3 1/2 89	2 7/32 56	1 3/8 35	27 33	0.8 0.4	
1 1/2 x 1 40 x 25	1.900 x 1.315 48.3 x 33.7	1 3/16 30	1 1/4 32	2 9/32 58	3 1/2 89	2 7/32 56	1 1/2 38	27 33	0.9 0.4	
2 x 1/2 50 x 15	2.375 x 0.840 60.3 x 21.3	1 3/16 30	1 1/4 32	2 1/2 64	3 7/8 98	2 7/32 56	1 5/8 42	27 33	0.8 0.4	
2 x 3/4 50 x 20	2.375 x 1.050 60.3 x 26.7	1 3/16 30	1 1/4 32	2 1/2 64	3 7/8 98	2 7/32 56	1 5/8 42	27 33	0.8 0.4	
2 x 1 50 x 25	2.375 x 1.315 60.3 x 33.7	1 3/16 30	1 1/4 32	2 9/8 67	3 7/8 98	2 7/32 56	1 3/4 45	27 33	0.9 0.4	
2 1/2 x 1/2 65 x 15	2.875 x 0.840 73.0 x 21.3	1 3/16 30	1 1/4 32	2 11/16 69	4 3/8 111	2 7/32 56	2 51	27 33	0.8 0.4	
2 1/2 x 3/4 65 x 20	2.875 x 1.050 73.0 x 26.7	1 3/16 30	1 1/4 32	2 11/16 69	4 3/8 111	2 7/32 56	2 51	27 33	0.9 0.4	
2 1/2 x 1 65 x 25	2.875 x 1.315 73.0 x 33.7	1 3/16 30	1 1/4 32	2 13/16 72	4 3/8 111	2 7/32 56	2 1/8 54	27 33	1.0 0.5	

## Grooved Fittings

**FIG. 7050**

90° ELBOW\*



C - Cast malleable or ductile iron, all others are fabricated steel.

\* 14"-24" Standard Radius 90° Elbows are 1½".

Center to end dimensions and weights may differ from those shown in chart, contact a Anvil Representative for more information.

**FIGURE 7050 90° ELBOW\***

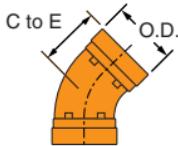
Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	2½ C	0.6
25	33.4	57	0.3
1¼	1.660	2¾ C	1.0
32	42.2	70	0.5
1½	1.900	2¾ C	1.2
40	48.3	70	0.5
2	2.375	3¼ C	1.7
50	60.3	83	0.8
2½	2.875	3¾ C	2.6
65	73.0	95	1.2
3 O.D.	2.996	4 C	3.6
76.1	76.1	102	1.6
3	3.500	4¼ C	4.0
80	88.9	108	1.8
3½	4.000	4½ C	5.5
90	101.6	114	2.5

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
4½ O.D.	4.250	4¾ C	7.7
108.0	108.0	121	3.5
4	4.500	5 C	7.7
100	114.3	127	3.5
5¼ O.D.	5.236	5½ C	10.4
133.0	133.0	133	4.7
5½ O.D.	5.500	5¾ C	10.9
139.7	139.7	133	4.9
5	5.563	5½ C	11.1
125	141.3	140	5.0
6¼ O.D.	6.259	6 C	15.2
159.0	159.0	152	6.9
6½ O.D.	6.500	6½ C	17.4
165.1	165.1	165	7.9
6	6.625	6½ C	16.5
150	168.3	165	7.5

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
8	8.625	7¾ C	30.6
200	219.1	197	13.9
10	10.750	9 C	53.5
250	273.1	229	24.3
12	12.750	10 C	82
300	323.9	254	37.2
14	14.000	21	169.0
350	355.6	533	76.7
16	16.000	24	222.0
400	406.4	610	100.7
18	18.000	27	280.0
450	457.2	686	127.0
20	20.000	30	344.0
500	508.0	762	156.0
24	24.000	36	490.0
600	609.6	914	222.3

**FIG. 7051**

45° ELBOW\*



C - Cast malleable or ductile iron, all others are fabricated steel.

\* 14"-24" Standard Radius 45° Elbows are 1½".

Center to end dimensions and weights may differ from those shown in chart, contact a Anvil Representative for more information.

**FIGURE 7051 45° ELBOW\***

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1 25	1.315 33.4	1¾ C 44	0.5 0.2
1¼ 32	1.660 42.2	1¾ C 44	0.7 0.3
1½ 40	1.900 48.3	1¾ C 44	0.9 0.4
2 50	2.375 60.3	2 C 51	1.5 0.7
2½ 65	2.875 73.0	2¼ C 57	1.9 0.9
3 O.D. 76.1	2.996 76.1	2½ C 64	2.2 1.0
3 80	3.500 88.9	2½ C 64	3.3 1.5
3½ 90	4.000 101.6	2¾ C 70	4.3 2.0

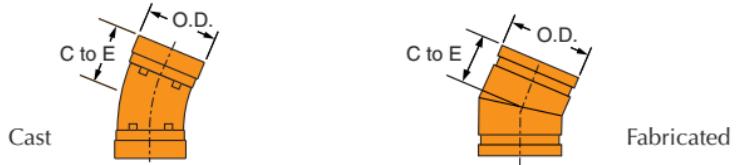
Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4½ O.D. 108.0	4.250 108.0	2⅜ C 83	4.4 2.0
4 100	4.500 114.3	3 C 76	5.4 2.4
5¼ O.D. 133.0	5.236 133.0	3⅓ C 83	7.3 3.3
5½ O.D. 139.7	5.500 139.7	3⅔ C 83	7.8 3.5
5 125	5.563 141.3	3⅔ C 83	9.0 4.1
6¼ O.D. 159.0	6.259 159.0	3⅔ C 89	10.1 4.6
6½ O.D. 165.1	6.500 165.1	3⅔ C 89	11.1 5.0
6 150	6.625 168.3	3⅔ C 89	11.2 5.1

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
8 200	8.625 219.1	4½ C 108	19.8 9.0
10 250	10.750 273.1	4¾ C 121	34.3 15.6
12 300	12.750 323.9	5¼ C 133	50.0 22.7
14 350	14.000 355.6	8¾ C 222	92.0 41.7
16 400	16.000 406.4	10 C 254	117.0 53.1
18 450	18.000 457.2	11½ C 286	146.0 66.2
20 500	20.000 508.0	12½ C 317	179.0 81.2
24 600	24.000 609.6	15 C 381	255.0 115.7

## Grooved Fittings

**FIG. 7052**

22½° ELBOW



**FIGURE 7052 22½° ELBOW**

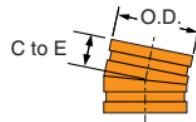
Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	3 1/4	0.5
25	33.4	83	0.2
1 1/4	1.660	1 1/4	0.7
32	42.2	44	0.3
1 1/2	1.900	1 3/4	0.8
40	48.3	44	0.4
2	2.375	1 7/8 C	1.5
50	60.3	48	0.7
2 1/2	2.875	2	1.9
65	73.0	51	0.9
3	3.500	2 1/4 C	3.2
80	88.9	57	1.5
3 1/2	4.000	2 1/2	4.0
90	101.6	64	1.8
4	4.500	2 5/8 C	5.3
100	114.3	67	2.4

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
5	5.563	2 7/8	7.2
125	141.3	73	3.3
6	6.625	3 1/8 C	8.2
150	168.3	79	3.7
8	8.625	3 1/8 C	17.8
200	219.1	98	8.1
10	10.750	4 3/8	30.0
250	273.1	111	13.6
12	12.750	4 7/8	40.4
300	323.9	124	18.3
14	14.000	5	46.0
350	355.6	127	20.9
16	16.000	5	52.2
400	406.4	127	23.7
18	18.000	5 1/2	65.0
450	457.2	140	29.5

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
20	20.000	6	80.0
500	508.0	152	36.3
24	24.000	7	112.0
600	609.6	178	50.8

C - Cast malleable or ductile iron, all others are fabricated steel.

Center to end dimensions and weights may differ from those shown in chart, contact a Anvil Representative for more information.

**FIG. 7053**11 $\frac{1}{4}$ <sup>o</sup> ELBOW**FIGURE 7053 11 $\frac{1}{4}$ <sup>o</sup> ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	1 $\frac{1}{8}$	0.3
25	33.4	35	0.1
1 $\frac{1}{4}$	1.660	1 $\frac{1}{8}$	0.5
32	42.2	35	0.2
1 $\frac{1}{2}$	1.900	1 $\frac{1}{8}$	0.7
40	48.3	35	0.3
2	2.375	1 $\frac{1}{8}$	0.9
50	60.3	35	0.4
2 $\frac{1}{2}$	2.875	1 $\frac{1}{2}$	1.5
65	73.0	38	0.7
3	3.500	1 $\frac{1}{2}$	2.0
80	88.9	38	0.9
3 $\frac{1}{2}$	4.000	1 $\frac{1}{4}$	2.8
90	101.6	44	1.3
4	4.500	1 $\frac{1}{4}$	3.3
100	114.3	44	1.5

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
5	5.563	2	5.0
125	141.3	51	2.3
6	6.625	2	6.5
150	168.3	51	2.9
8	8.625	2	10.0
200	219.1	51	4.5
10	10.750	2 $\frac{1}{8}$	14.5
250	273.1	54	6.6
12	12.750	2 $\frac{1}{4}$	18.7
300	323.9	57	8.5
14	14.000	3 $\frac{1}{2}$	32.1
350	355.6	89	14.6
16	16.000	4	42.0
400	406.4	102	19.1
18	18.000	4 $\frac{1}{2}$	53.2
450	457.2	114	24.1

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
20	20.000	5	65.7
500	508.0	127	29.8
24	24.000	6	96.0
600	609.6	152	43.5

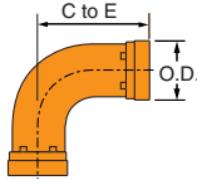
C - Cast malleable or ductile iron, all others are fabricated steel.

Center to end dimensions and weights may differ from those shown in chart, contact a Anvil Representative for more information.

## Grooved Fittings

**FIG. 7050 LR**

90° LONG RADIUS ELBOW\*



**FIGURE 7050 LR 90° LONG RADIUS ELBOW\***

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1	1.315	3½	0.9
25	33.4	89	0.4
1¼	1.660	3⅜	1.3
32	42.2	98	0.6
1½	1.900	4¼	1.7
40	48.3	108	0.8
2	2.375	4¾ C	2.5
50	60.3	136	1.1
2½	2.875	5¾	4.9
65	73.0	146	2.2
3	3.500	5½ C	6.5
80	88.9	181	2.9
3½	4.000	7¼	9.7
90	101.6	184	4.4
4	4.500	7½ C	11.5
100	114.3	191	5.2

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
5	5.563	9½	20.9
125	141.3	241	9.5
6	6.625	10¾	29.1
150	168.3	273	13.2
8	8.625	15	59.2
200	219.1	381	26.9
10	10.750	18	104.0
250	273.1	457	47.2
12	12.750	21	147.0
300	323.9	533	66.7
14	14.000	21	169.0
350	355.6	533	76.7
16	16.000	24	222.0
400	406.4	610	100.7
18	18.000	27	280.0
450	457.2	686	127.0

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
20	20.000	30	344.0
500	508.0	762	156.0
24	24.000	36	490.0
600	609.6	914	222.3

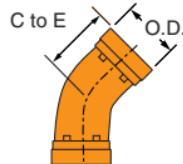
C - Cast malleable or ductile iron, all others are fabricated steel.

\* 14"-24" Standard Radius 90° Elbows are 1½".

Center to end dimensions and weights may differ from those shown in chart, Contact a Anvil Representative for more information.

**FIG. 7051LR**

45° LONG RADIUS ELBOW\*

**FIG. 7051LR 45° LONG RADIUS ELBOW\***

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1	1.315	2½	0.7
25	33.4	64	0.3
1¼	1.660	2½	1.0
32	42.2	64	0.5
1½	1.900	2½	1.2
40	48.3	64	0.5
2	2.375	2¾	1.7
50	60.3	70	0.8
2½	2.875	3	2.9
65	73.0	76	1.3
3	3.500	3¾	4.3
80	88.9	86	2.0
3½	4.000	3½	5.3
90	101.6	89	2.4
4	4.500	4	7.2
100	114.3	102	3.3

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
5	5.563	5	12.2
125	141.3	127	5.5
6	6.625	5½	17.4
150	168.3	140	7.9
8	8.625	7¼	34.0
200	219.1	184	15.4
10	10.750	8½	57.4
250	273.1	216	26.0
12	12.750	10	82.6
300	323.9	254	37.5
14	14.000	21	169.0
350	355.6	222	41.7
16	16.000	10	117.0
400	406.4	254	53.1
18	18.000	11¼	146.0
450	457.2	286	66.2

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
20	20.000	12½	179.0
500	508.0	317	81.2
24	24.000	15	255.0
600	609.6	381	115.7

C - Cast malleable or ductile iron, all others are fabricated steel.

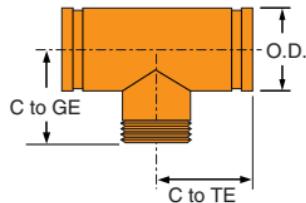
\* 14"-24" Standard Radius 45° Elbows are 1½".

Center to end dimensions and weights may differ from those shown in chart, Contact a Anvil Representative for more information.

## Grooved Fittings

**FIG. 7063**

TEE W/ THREADED BRANCH



**FIGURE 7063 TEE WITH THREADED BRANCH**

Nominal Size	O.D.	C to GE	C to TE	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	2 $\frac{1}{4}$	2 $\frac{1}{4}$	0.9
25	33.4	57	57	0.4
1 $\frac{1}{4}$	1.660	2 $\frac{3}{4}$	2 $\frac{3}{4}$	1.4
32	42.2	70	70	0.6
1 $\frac{1}{2}$	1.900	2 $\frac{3}{4}$	2 $\frac{3}{4}$	1.7
40	48.3	70	70	0.8
2	2.375	3 $\frac{1}{4}$	4 $\frac{1}{4}$	2.9
50	60.3	83	108	1.3
2 $\frac{1}{2}$	2.875	3 $\frac{3}{4}$	3 $\frac{3}{4}$	4.7
65	73.0	95	95	2.1
3	3.500	4 $\frac{1}{4}$	6	8.1
80	88.9	108	152	3.7
3 $\frac{1}{2}$	4.000	4 $\frac{1}{2}$	4 $\frac{1}{2}$	8.8
90	101.6	114	114	4.0

Nominal Size	O.D.	C to GE	C to TE	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
4	4.500	5	7 $\frac{1}{4}$	13.5
100	114.3	127	184	6.1
5	5.563	5 $\frac{1}{2}$	5 $\frac{1}{2}$	16.7
125	140	140	7.6	7.6
6	6.625	6 $\frac{1}{2}$	6 $\frac{1}{2}$	25.6
150	168.3	165	165	11.6
8	8.625	7 $\frac{3}{4}$	7 $\frac{3}{4}$	45.0
200	219.1	197	197	20.4
10	10.750	9	9	73.0
250	273.1	229	229	33.1
12	12.750	10	10	98.0
300	323.9	254	254	44.5

C - Cast malleable or ductile iron, all others are fabricated steel.

FIG. 7061

REDUCING TEE STANDARD

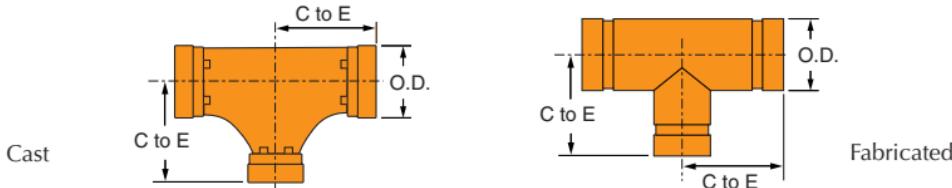


FIG. 7061 REDUCING TEE STANDARD (CONTINUED ON NEXT PAGE)

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1 1/4 x 1 1/4 x 1 32 x 32 x 25	2 3/4 70	1.5 0.7
1 1/2 x 1 1/2 x 1 40 x 40 x 25	2 3/4 70	1.8 0.8
1 1/2 x 1 1/2 x 1 1/4 40 x 40 x 32	2 3/4 70	1.8 0.8
2 x 2 x 1 50 x 50 x 25	3 1/4 C 83	2.6 1.2
2 x 2 x 1 1/4 50 x 50 x 32	3 1/4 83	1.7 0.8
2 x 2 x 1 1/2 50 x 50 x 40	3 1/4 C 83	2.7 1.2
2 1/2 x 2 1/2 x 1 65 x 65 x 25	3 3/4 95	4.1 1.9
2 1/2 x 2 1/2 x 1 1/4 65 x 65 x 32	3 3/4 95	4.2 1.9

C - Cast malleable or ductile iron, all others are fabricated steel.

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2 1/2 x 2 1/2 x 1 1/2 65 x 65 x 40	3 3/4 95	4.3 2.0
2 1/2 x 2 1/2 x 2 65 x 65 x 50	3 3/4 95	4.4 2.0
3 x 3 x 1 80 x 80 x 25	4 1/4 C 108	7.0 3.2
3 x 3 x 1 1/4 80 x 80 x 32	4 1/4 108	5.8 2.6
3 x 3 x 1 1/2 80 x 80 x 40	4 1/4 108	5.9 2.7
3 x 3 x 2 80 x 80 x 50	4 1/4 C 108	5.5 2.5
3 x 3 x 2 1/2 80 x 80 x 65	4 1/4 108	6.3 2.9
4 x 4 x 1 100 x 100 x 25	3 3/4 95	7.0 3.2

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4 x 4 x 1 1/4 100 x 100 x 32	5 127	9.6 4.4
4 x 4 x 1 1/2 100 x 100 x 40	5 127	10.2 4.6
4 x 4 x 2 100 x 100 x 50	5 C 127	10.2 4.6
4 x 4 x 2 1/2 100 x 100 x 65	5 C 127	11.2 5.1
4 x 4 x 3 100 x 100 x 80	5 C 127	11.4 5.2
5 x 5 x 1 125 x 125 x 25	5 1/2 140	13.6 6.2
5 x 5 x 1 1/2 125 x 125 x 40	5 1/2 140	13.8 6.3
5 x 5 x 2 125 x 125 x 50	5 1/2 140	14 6.4

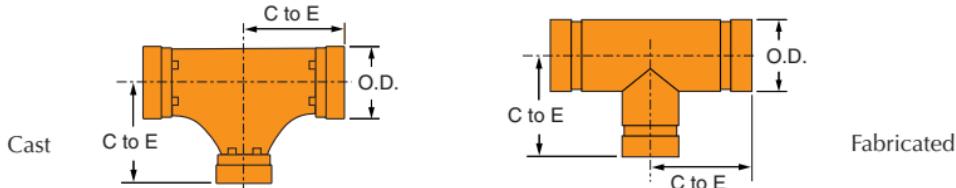
Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
5 x 5 x 2 1/2 125 x 125 x 65	5 1/2 140	14.3 6.5
5 x 5 x 3 125 x 125 x 80	5 1/2 140	14.6 6.6
5 x 5 x 4 125 x 125 x 100	5 1/2 C 140	17.9 8.1
6 x 6 x 1 150 x 150 x 25	6 1/2 165	20.5 9.3
6 x 6 x 1 1/2 150 x 150 x 40	6 1/2 165	21.0 9.5
6 x 6 x 2 150 x 150 x 50	6 1/2 C 165	26.4 12.0
6 x 6 x 2 1/2 150 x 150 x 65	6 1/2 C 165	26.5 12.0
6 x 6 x 3 150 x 150 x 80	6 1/2 C 165	26.5 12.0

See Fitting Size Chart on page 148 for O.D. sizes

## Grooved Fittings

**FIG. 7061, CONT'D.**

REDUCING TEE STANDARD



**FIG. 7061 REDUCING TEE STANDARD (CONTINUED ON NEXT PAGE)**

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
6 x 6 x 4	6½ C	26.5
150 x 150 x 100	165	12.0
6 x 6 x 5	6½ C	28.0
150 x 150 x 125	165	12.7
8 x 8 x 1½	7¾	33.0
200 x 200 x 40	197	15.0
8 x 8 x 2	7¾	32.7
200 x 200 x 50	197	14.8
8 x 8 x 2½	7¾	33.0
200 x 200 x 65	197	15.0
8 x 8 x 3	7¾	33.5
200 x 200 x 80	197	15.2
8 x 8 x 4	7¾ C	50.0
200 x 200 x 100	197	22.7
8 x 8 x 5	7¾	34.7
200 x 200 x 125	197	15.7
8 x 8 x 6	7¾ C	54.0
200 x 200 x 150	197	24.5

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
10 x 10 x 1½	9	52.0
250 x 250 x 40	229	23.6
10 x 10 x 2	9	52.2
250 x 250 x 50	229	23.7
10 x 10 x 2½	9	52.6
250 x 250 x 65	229	23.9
10 x 10 x 3	9	53.0
250 x 250 x 80	229	24.0
10 x 10 x 4	9	53.6
250 x 250 x 100	229	24.3
10 x 10 x 5	9	54.2
250 x 250 x 125	229	24.6
10 x 10 x 6	9 C	55.0
250 x 250 x 150	229	24.9
10 x 10 x 8	9 C	64.7
250 x 250 x 200	229	29.3
12 x 12 x 1	10	77.0
300 x 300 x 25	254	34.9

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
12 x 12 x 2	10	80.0
300 x 300 x 50	254	36.3
12 x 12 x 2½	10	78.0
300 x 300 x 65	254	35.4
12 x 12 x 3	10	74.6
300 x 300 x 80	254	33.8
12 x 12 x 4	10	75.1
300 x 300 x 100	254	34.1
12 x 12 x 5	10	75.6
300 x 300 x 125	254	34.3
12 x 12 x 6	10	76.2
300 x 300 x 150	254	34.6
12 x 12 x 8	10	76.3
300 x 300 x 200	254	34.6
12 x 12 x 10	10	77.6
300 x 300 x 250	254	35.2
14 x 14 x 4	11	100.0
350 x 350 x 100	279	45.4

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
14 x 14 x 6	11	101
350 x 350 x 150	279	45.8
14 x 14 x 8	11	103
350 x 350 x 200	279	46.7
14 x 14 x 10	11	104
350 x 350 x 250	279	47.2
14 x 14 x 12	11	105
350 x 350 x 300	279	47.6
16 x 16 x 4	12	126
400 x 400 x 100	305	57.2
16 x 16 x 6	12	127
400 x 400 x 150	305	57.6
16 x 16 x 8	12	128
400 x 400 x 200	305	58.1
16 x 16 x 10	12	129
400 x 400 x 250	305	58.5
16 x 16 x 12	12	130
400 x 400 x 300	305	59.0

**FIG. 7061, CONT'D.**

REDUCING TEE STANDARD

**FIG. 7061 REDUCING TEE STANDARD (CONT'D. FROM PREVIOUS PAGE)**

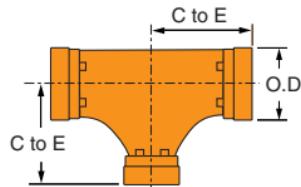
Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
16 x 16 x 14	12	132
400 x 400 x 350	305	59.9
18 x 18 x 4	15½	188
450 x 450 x 100	394	85.3
18 x 18 x 6	15½	190
450 x 450 x 150	394	86.2
18 x 18 x 8	15½	192
450 x 450 x 200	394	87.1
18 x 18 x 10	15½	194
450 x 450 x 250	394	88.0
18 x 18 x 12	15½	196
450 x 450 x 300	394	88.9
18 x 18 x 14	15½	201
450 x 450 x 350	394	91.2
18 x 18 x 16	15½	203
450 x 450 x 400	394	92.1
20 x 20 x 6	17¼	240
500 x 500 x 150	438	108.9
20 x 20 x 8	17¼	242
500 x 500 x 200	438	109.8
20 x 20 x 10	17¼	244
500 x 500 x 250	438	110.7

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
20 x 20 x 12	17¼	246
500 x 500 x 300	438	111.6
20 x 20 x 14	17¼	248
500 x 500 x 350	438	112.5
20 x 20 x 16	17¼	250
500 x 500 x 400	438	113.4
20 x 20 x 18	17¼	252
500 x 500 x 450	438	114.3
24 x 24 x 8	20	327
600 x 600 x 200	508	148.3
24 x 24 x 10	20	330
600 x 600 x 250	508	149.7
24 x 24 x 12	20	334
600 x 600 x 300	508	151.5
24 x 24 x 14	20	340
600 x 600 x 350	508	154.2
24 x 24 x 16	20	342
600 x 600 x 400	508	155.1
24 x 24 x 18	20	345
600 x 600 x 450	508	156.5
24 x 24 x 20	20	347
600 x 600 x 500	508	157.4

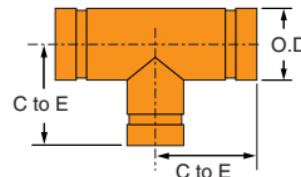
C - Cast malleable or ductile iron, all others are fabricated steel.

See Fitting Size Chart on page 148  
for O.D. sizes

Cast



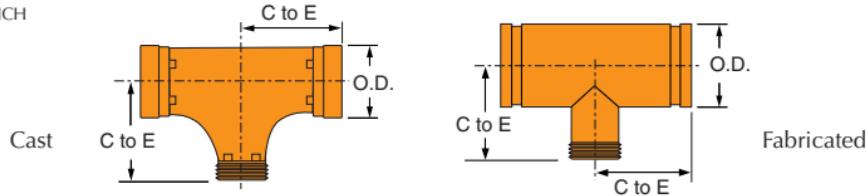
Fabricated



## Grooved Fittings

**FIG. 7064**

REDUCING TEE W/ THREADED BRANCH



**FIGURE 7064 REDUCING TEE W/THREADED BRANCH (CONTINUED ON NEXT PAGE)**

Nominal Size	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs/Kg
2 x 2 x 3 $\frac{3}{4}$ 50 x 50 x 20	3 $\frac{1}{4}$ 83	1.6 0.7
2 x 2 x 1 50 x 50 x 25	3 $\frac{1}{4}$ C 83	2.6 1.2
2 x 2 x 1 $\frac{1}{4}$ 50 x 50 x 32	3 $\frac{1}{4}$ 83	1.7 0.8
2 x 2 x 1 $\frac{1}{2}$ 50 x 50 x 40	3 $\frac{1}{4}$ C 83	2.7 1.2
2 $\frac{1}{2}$ x 2 $\frac{1}{2}$ x 1 65 x 65 x 25	3 $\frac{1}{4}$ 95	4.1 1.9
2 $\frac{1}{2}$ x 2 $\frac{1}{2}$ x 1 $\frac{1}{2}$ 65 x 65 x 40	3 $\frac{1}{4}$ 95	4.3 2
2 $\frac{1}{2}$ x 2 $\frac{1}{2}$ x 2 65 x 65 x 50	3 $\frac{1}{4}$ 95	4.4 2
3 x 3 x 3 $\frac{1}{4}$ 80 x 80 x 20	4 $\frac{1}{4}$ 108	5.7 2.6

Nominal Size	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs/Kg
3 x 3 x 1 80 x 80 x 25	4 $\frac{1}{4}$ C 108	7.0 3.2
3 x 3 x 1 $\frac{1}{2}$ 80 x 80 x 40	4 $\frac{1}{4}$ 108	5.3 2.4
3 x 3 x 2 80 x 80 x 50	4 $\frac{1}{4}$ 108	5.5 2.5
3 x 3 x 2 $\frac{1}{2}$ 80 x 80 x 65	4 $\frac{1}{4}$ 108	5.8 2.6
4 x 4 x 3 $\frac{3}{4}$ 100 x 100 x 20	3 $\frac{1}{4}$ 95	7.2 3.3
4 x 4 x 1 100 x 100 x 25	3 $\frac{1}{4}$ 95	7.0 3.2
4 x 4 x 1 $\frac{1}{2}$ 100 x 100 x 40	5 127	9.2 4.2
4 x 4 x 2 100 x 100 x 50	5 127	10.2 4.6

Nominal Size	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs/Kg
4 x 4 x 2 $\frac{1}{2}$ 100 x 100 x 65	5 127	11.2 5.1
4 x 4 x 3 100 x 100 x 80	5 127	11.4 5.2
5 x 5 x 2 125 x 125 x 50	5 $\frac{1}{2}$ 140	14.5 6.6
5 x 5 x 3 125 x 125 x 80	5 $\frac{1}{2}$ 140	16.1 7.3
5 x 5 x 4 125 x 125 x 100	5 $\frac{1}{2}$ C 140	17.9 8.1
6 x 6 x 2 150 x 150 x 50	6 $\frac{1}{2}$ 165	26.4 12
6 x 6 x 2 $\frac{1}{2}$ 150 x 150 x 65	6 $\frac{1}{2}$ 165	26.5 12
6 x 6 x 3 150 x 150 x 80	6 $\frac{1}{2}$ 165	26.5 12

Nominal Size	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs/Kg
6 x 6 x 4 150 x 150 x 100	6 $\frac{1}{2}$ 165	26.5 12
6 x 6 x 5 150 x 150 x 125	6 $\frac{1}{2}$ C 165	28.0 12.7
8 x 8 x 2 200 x 200 x 50	7 $\frac{1}{4}$ 197	37.5 17
8 x 8 x 3 200 x 200 x 80	7 $\frac{1}{4}$ 197	38.7 17.6
8 x 8 x 4 200 x 200 x 100	7 $\frac{1}{4}$ 197	50.0 22.7
8 x 8 x 5 200 x 200 x 125	7 $\frac{1}{4}$ 197	41.0 18.6
8 x 8 x 6 200 x 200 x 150	7 $\frac{1}{4}$ 197	54.0 24.5
10 x 10 x 2 250 x 250 x 50	9 229	61.8 28.0

FIG. 7064, CONT'D.

REDUCING TEE W/ THREADED BRANCH

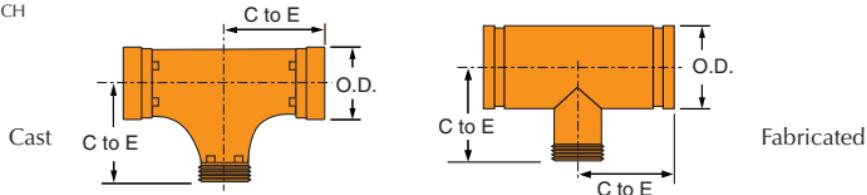


FIGURE 7064 REDUCING TEE W/ THREADED BRANCH (CONTINUED FROM PREVIOUS PAGE)

Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs/Kg</i>	Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs/Kg</i>	Nominal Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs/Kg</i>
10 x 10 x 3 250 x 250 x 80	9 229	63.0 28.6	12 x 12 x 6 300 x 300 x 150	10 254	88.3 40.1	16 x 16 x 12 400 x 400 x 300	12 305	142.0 64.4
10 x 10 x 4 250 x 250 x 100	9 229	64.0 29.0	12 x 12 x 8 300 x 300 x 200	10 254	91.2 41.4	18 x 18 x 10 450 x 450 x 250	15½ 394	204.0 92.5
10 x 10 x 5 250 x 250 x 125	9 229	65.1 29.5	12 x 12 x 10 300 x 300 x 250	10 254	94.8 43.0	18 x 18 x 12 450 x 450 x 300	15½ 394	209.0 94.8
10 x 10 x 6 250 x 250 x 150	9 229	55.0 24.9	14 x 14 x 8 350 x 350 x 200	11 279	110.0 49.7	18 x 18 x 14 450 x 450 x 350	15½ 394	211.0 95.7
10 x 10 x 8 250 x 250 x 200	9 229	64.7 29.3	14 x 14 x 10 350 x 350 x 250	11 279	114.0 51.5	18 x 18 x 16 450 x 450 x 400	15½ 394	216.0 98.0
12 x 12 x 3 300 x 300 x 80	10 254	84.9 38.5	14 x 14 x 12 350 x 350 x 300	11 279	117.0 52.8	24 x 24 x 8 600 x 600 x 200	20 508	334.0 152
12 x 12 x 4 300 x 300 x 100	10 254	85.8 38.9	16 x 16 x 8 400 x 400 x 200	12 305	135.0 61.2	24 x 24 x 10 600 x 600 x 250	20 508	342.0 155
12 x 12 x 5 300 x 300 x 125	10 254	87.0 39.5	16 x 16 x 10 400 x 400 x 250	12 305	139.0 63.0	24 x 24 x 12 600 x 600 x 300	20 508	349.0 158

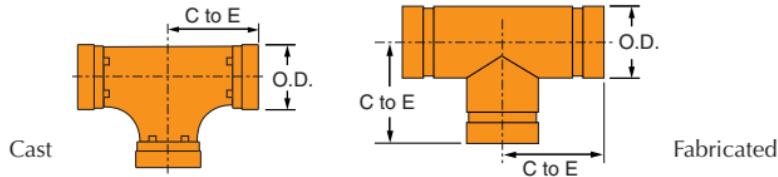
See Fitting Size Chart on page 148 for O.D. sizes

C - Cast malleable or ductile iron, all others are fabricated steel.

## Grooved Fittings

**FIG. 7060**

T<sub>EE</sub>



**FIG. 7060 T<sub>EE</sub>**

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1	1.315	2 <sup>1</sup> / <sub>4</sub> C	0.9
25	33.4	57	0.4
1 <sup>1</sup> / <sub>4</sub>	1.660	2 <sup>3</sup> / <sub>4</sub> C	1.5
32	42.2	70	0.7
1 <sup>1</sup> / <sub>2</sub>	1.900	2 <sup>3</sup> / <sub>4</sub> C	1.8
40	48.3	70	0.8
2	2.375	3 <sup>1</sup> / <sub>4</sub> C	2.4
50	60.3	83	1.1
2 <sup>1</sup> / <sub>2</sub>	2.875	3 <sup>3</sup> / <sub>4</sub> C	4.0
65	73.0	95	1.8
3 O.D.	2.996	4 C	4.6
76.1	76.1	101	2.1
3	3.500	4 <sup>1</sup> / <sub>4</sub> C	5.8
80	88.9	108	2.6
3 <sup>1</sup> / <sub>2</sub>	4.000	4 <sup>1</sup> / <sub>2</sub> C	9.8
90	101.6	114	4.4

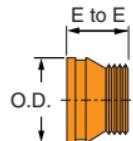
Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4 <sup>1</sup> / <sub>4</sub> O.D.	4.250	4 <sup>3</sup> / <sub>4</sub> C	9.3
108.0	108.0	121	4.2
4	4.500	5 C	10.3
100	114.3	127	4.7
5 <sup>1</sup> / <sub>4</sub> O.D.	5.236	5 <sup>1</sup> / <sub>4</sub> C	14.1
133.0	133.0	133	6.4
5 <sup>1</sup> / <sub>2</sub> O.D.	5.500	5 <sup>1</sup> / <sub>2</sub> C	16.1
139.7	139.7	140	7.3
5	5.563	5 <sup>1</sup> / <sub>2</sub> C	16.2
125	141.3	140	7.3
6 <sup>1</sup> / <sub>4</sub> O.D.	6.259	6 C	20.8
159.0	159.0	152	9.4
6 <sup>1</sup> / <sub>2</sub> O.D.	6.500	6 <sup>1</sup> / <sub>2</sub> C	24.4
165.1	165.1	165	11.1
6	6.625	6 <sup>1</sup> / <sub>2</sub> C	25.7
150	168.3	165	11.7

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
8	8.625	7 <sup>3</sup> / <sub>4</sub> C	41.1
200	219.1	197	18.6
10	10.750	9 C	74.5
250	273.1	229	33.8
12	12.750	10 C	94.7
300	323.9	254	43.0
14	14.000	11	118.0
350	355.6	279	53.5
16	16.000	12	146.0
400	406.4	305	66.2
18	18.000	15 <sup>1</sup> / <sub>2</sub>	218.0
450	457.2	394	98.9
20	20.000	17 <sup>1</sup> / <sub>4</sub>	275.0
500	508.0	438	125
24	24.000	20	379.0
600	609.6	508	172

C - Cast malleable or ductile iron, all others are fabricated steel.

**FIG. 7076**

GR X THD CONCENTRIC REDUCERS

**FIG. 7076 GR X THD CONCENTRIC REDUCERS**

Nominal Size <i>In./DN(mm)</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1½ x 1 40 x 25	2½ 64	0.6 0.3
2 x ¾ 50 x 80	2½ 64	1.0 0.5
2 x 1 50 x 25	2½ 64	0.8 0.4
2 x 1¼ 50 x 32	2½ 64	1.3 0.6
2 x 1½ 50 x 40	2½ 64	1.3 0.6
2½ x 1 65 x 25	2½ 64	1.0 0.5
2½ x 1¼ 65 x 32	2½ 64	1.0 0.5

Nominal Size <i>In./DN(mm)</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2½ x 1½ 65 x 40	2½ 64	1.3 0.6
2½ x 2 65 x 50	2½ 64	1.2 0.5
3 x ¾ 80 x 80	2½ 64	1.2 0.5
3 x 1 80 x 25	2½ 64	1.2 0.5
3 x 1½ 80 x 40	2½ 64	1.3 0.6
3 x 2 80 x 50	2½ 64	1.3 0.6
3 x 2½ 80 x 65	2½ 64	1.5 0.7

Nominal Size <i>In./DN(mm)</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
3½ x 3 90 x 80	3 76	1.8 0.8
4 x 1 100 x 25	3 76	2.2 1.0
4 x 1½ 100 x 40	3 76	2.3 1.0
4 x 2 100 x 50	3 76	2.3 1.0
4 x 2½ 100 x 65	3 76	2.3 1.0
4 x 3 100 x 80	3 76	2.6 1.2
4 x 3½ 100 x 90	3 76	2.5 1.1

Nominal Size <i>In./DN(mm)</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
5 x 4 125 x 100	3½ 89	4.5 2.0
6 x 1 150 x 25	4 102	6.0 2.7
6 x 2 150 x 50	4 102	6.0 2.7
6 x 3 150 x 80	4 102	6.0 2.7
6 x 4 150 x 100	4 102	5.9 2.7
6 x 5 150 x 125	4 102	5.8 2.6

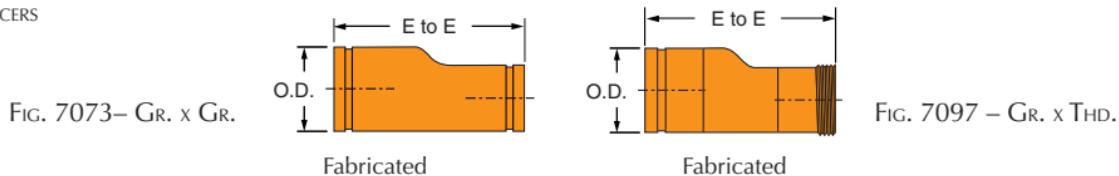
All are Fabricated Steel.

See Fitting Size Chart on page 148 for O.D. sizes

## Grooved Fittings

**FIG. 7073 & FIG. 7097**

ECCENTRIC REDUCERS



**FIGURE 7073 & 7097 ECCENTRIC REDUCERS (CONTINUED ON NEXT PAGE)**

Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg
1 1/4 x 1 32 x 25	8 1/2 216	1.5 0.7
1 1/2 x 3/4 40 x 20	8 1/2 216	1.6 0.7
1 1/2 x 1 40 x 25	8 1/2 216	1.7 0.8
1 1/2 x 1 1/4 40 x 32	8 1/2 216	4.5 2.0
2 x 3/4 50 x 80	9 229	2.1 1.0
2 x 1 50 x 25	9 229	2.2 1.0
2 x 1 1/4 50 x 32	9 229	2.4 1.1
2 x 1 1/2 50 x 40	9 229	2.5 1.1

Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg
2 1/2 x 1 65 x 25	9 1/2 241	3.2 1.5
2 1/2 x 1 1/4 65 x 32	9 1/2 241	3.4 1.5
2 1/2 x 1 1/2 65 x 40	9 1/2 241	3.6 1.6
2 1/2 x 2 65 x 50	9 1/2 241	4.0 1.8
3 x 1 80 x 25	9 1/2 241	4.0 1.8
3 x 1 1/4 80 x 32	9 1/2 241	4.3 2.0
3 x 1 1/2 80 x 40	9 1/2 241	4.5 2.0
3 x 2 80 x 50	9 1/2 241	4.8 2.2

Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg
3 x 2 1/2 80 x 65	9 1/2 241	5.6 2.5
3 1/2 x 3 90 x 80	9 1/2 241	6.6 3.0
4 x 1 100 x 25	10 254	5.9 2.7
4 x 1 1/4 100 x 32	10 254	6.3 2.9
4 x 1 1/2 100 x 40	10 254	6.4 2.9
4 x 2 100 x 50	10 254	6.7 3.0
4 x 2 1/2 100 x 65	10 254	7.3 3.3
4 x 3 100 x 80	10 254	7.9 3.6

Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg
4 x 3 1/2 100 x 90	10 254	8.5 3.9
5 x 2 125 x 50	11 279	9.3 4.2
5 x 2 1/2 125 x 65	11 279	9.9 4.5
5 x 3 125 x 80	11 279	10.7 4.9
5 x 4 125 x 100	11 279	11.9 5.4
6 x 1 150 x 25	11 1/2 292	12.0 5.4
6 x 1 1/2 150 x 40	11 1/2 292	12.1 5.5
6 x 2 150 x 50	11 1/2 292	12.2 5.5

See Fitting Size Chart on page 148 for O.D. sizes

For Gruvlok Technical Detail Refer to the Gruvlok Catalog or contact your Anvil local sales representative.

[www.anvilintl.com](http://www.anvilintl.com)

**FIG. 7073 & FIG. 7097, CONT'D.**

## ECCENTRIC REDUCERS

**FIGURE 7073 & 7097 ECCENTRIC REDUCERS (CONTINUED FROM PREVIOUS PAGE)**

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
6 x 2½	11½	12.8
150 x 65	292	5.8
6 x 3	11½	13.6
150 x 80	292	6.2
6 x 4	11½	14.9
150 x 100	292	6.8
6 x 5	11½	16.2
150 x 125	292	7.3
8 x 3	12	17.9
200 x 80	305	8.1
8 x 4	12	19.7
200 x 100	305	8.9
8 x 5	12	21.4
200 x 125	305	9.7
8 x 6	12	23.2
200 x 150	305	10.5
10 x 4	13	29.7
250 x 100	330	13.5
10 x 5	13	31.7
250 x 125	330	14.4

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
10 x 6	13	34.0
250 x 150	330	15.4
10 x 8	13	34.4
250 x 200	330	15.6
12 x 4	14	44.8
300 x 100	356	20.3
12 x 6	14	45.2
300 x 150	356	20.5
12 x 8	14	47.7
300 x 200	356	21.6
12 x 10	14	52.0
300 x 250	356	23.6
14 x 6	13	78
350 x 150	330	35.4
14 x 8	13	80
350 x 200	330	36.3
14 x 10	13	84
350 x 250	330	38.1
14 x 12	13	88
350 x 300	330	39.9

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
16 x 8	14	91
400 x 200	356	41.3
16 x 10	14	96
400 x 250	356	43.5
16 x 12	14	99
400 x 300	356	44.9
16 x 14	14	104
400 x 350	356	47.2
18 x 10	15	110
450 x 250	381	49.9
18 x 12	15	113
450 x 300	381	51.3
18 x 14	15	117
450 x 350	381	53.1
18 x 16	15	121
450 x 400	381	54.9
20 x 10	20	145
500 x 250	508	65.8
20 x 12	20	149
500 x 300	508	67.6

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
20 x 14	20	152
500 x 350	508	68.9
20 x 16	20	156
500 x 400	508	70.8
20 x 18	20	160
500 x 450	508	72.6
24 x 10	20	174
600 x 250	508	78.9
24 x 12	20	179
600 x 300	508	81.2
24 x 14	20	184
600 x 350	508	83.5
24 x 16	20	189
600 x 400	508	85.7
24 x 18	20	194
600 x 450	508	88
24 x 20	20	199
600 x 500	508	90.3

See Fitting Size Chart on page 148 for O.D. sizes

Fabricated Steel \*Figure 7097 is available in sizes 1¼ x 1 through 12 x 10.

Center to end dimensions may differ from those shown above. Contact a Anvil Representative for more information.

## Grooved Fittings

**FIG. 7077, FIG. 7078 & FIG. 7079**

SWAGED NIPPLES

FIG. 7077  
GR x GR

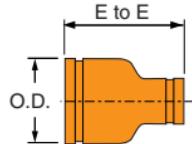


FIG. 7078  
GR x THD

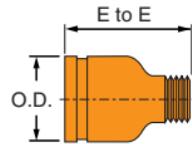
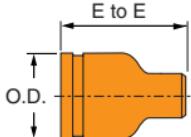


FIG. 7079  
GR x BEV



**FIGURE 7077, 7078 & 7079 SWAGED NIPPLES**

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
2 x 1	6½	2.0
50 x 25	165	0.9
2 x 1¼	6½	2.0
50 x 32	165	0.9
2 x 1½	6½	2.0
50 x 40	165	0.9
2½ x 1	7	3.5
65 x 25	178	1.6
2½ x 1¼	7	3.5
65 x 32	178	1.6
2½ x 1½	7	3.5
65 x 40	178	1.6
2½ x 2	7	3.5
65 x 50	178	1.6
3 x 1	8	5.0
80 x 25	203	2.3
3 x 1¼	8	5.0
80 x 32	203	2.3

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
3 x 1½	8	5.0
80 x 40	203	2.3
3 x 2	8	5.0
80 x 50	203	2.3
3 x 2½	8	5.0
80 x 65	203	2.3
3½ x 3	8	7.0
90 x 80	203	3.2
4 x 1	9	8.0
100 x 25	229	3.6
4 x 1¼	9	8.0
100 x 32	229	3.6
4 x 1½	9	8.0
100 x 40	229	3.6
4 x 2	9	8.0
100 x 50	229	3.6
4 x 2½	9	8.0
100 x 65	229	3.6

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
4 x 3	9	8.0
100 x 80	229	3.6
4 x 3½	9	8.0
100 x 90	229	3.6
5 x 2	11	12.0
125 x 50	279	5.4
5 x 2½	11	12.0
125 x 65	279	5.4
5 x 3	11	12.0
125 x 80	279	5.4
5 x 4	11	12.0
125 x 100	279	5.4
6 x 1	12	19.0
150 x 25	305	8.6
6 x 1¼	12	19.0
150 x 32	305	8.6
6 x 1½	12	19.0
150 x 40	305	8.6

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
6 x 2	12	19.0
150 x 50	305	8.6
6 x 2½	12	19.0
150 x 65	305	8.6
6 x 3	12	19.0
150 x 80	305	8.6
6 x 3½	12	17.0
150 x 90	305	7.7
6 x 4	12	19.0
150 x 100	305	8.6
6 x 5	12	19.0
150 x 125	305	8.6

See Fitting Size Chart on page 148 for O.D. sizes

FIG. 7072

GR x GR CONCENTRIC REDUCERS



FIGURE 7072 CONCENTRIC REDUCER (CONTINUED ON NEXT PAGE)

Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg	Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg	Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg	Nominal Size In./DN(mm)	End to End In./mm	Approx. Wt. Ea. Lbs./Kg
1 1/4 x 1 32 x 25	2 1/2 64	0.6 0.3	2 1/2 x 2 65 x 50	2 1/2 C 64	1.6 0.7	4 x 1 1/2 100 x 40	3 76	2.3 1.0	6 x 1 150 x 25	4 102	6.8 3.1
1 1/2 x 1 40 x 25	2 1/2 64	0.6 0.3	3 x 1 80 x 25	2 1/2 64	1.2 0.5	4 x 2 100 x 50	3 C 76	2.4 1.1	6 x 1 1/2 150 x 40	4 102	6.9 3.1
1 1/2 x 1 1/4 40 x 32	2 1/2 64	0.6 0.3	3 x 1 1/4 80 x 32	2 1/2 64	1.3 0.6	4 x 2 1/2 100 x 65	3 C 76	2.6 1.2	6 x 2 150 x 50	4 C 102	6.0 2.7
2 x 1 50 x 25	2 1/2 64	0.8 0.4	3 x 1 1/2 80 x 40	2 1/2 64	1.3 0.6	4 x 3 100 x 80	3 C 76	3.2 1.5	6 x 2 1/2 150 x 65	4 102	6.0 2.7
2 x 1 1/4 50 x 32	2 1/2 C 64	1.3 0.6	3 x 2 80 x 50	2 1/2 C 64	1.4 0.6	4 x 3 1/2 100 x 90	3 C 76	3.6 1.6	6 x 3 150 x 80	4 C 102	5.4 2.4
2 x 1 1/2 50 x 40	2 1/2 C 64	1.3 0.6	3 x 2 1/2 80 x 65	2 1/2 C 64	1.5 0.7	5 x 2 125 x 50	3 1/2 89	4.6 2.1	6 x 4 150 x 100	4 C 102	5.6 2.5
2 1/2 x 1 65 x 25	2 1/2 64	1.0 0.5	3 1/2 x 3 90 x 80	3 76	1.8 0.8	5 x 2 1/2 125 x 65	3 1/2 89	4.5 2.0	6 x 5 150 x 125	4 C 102	6.0 2.7
2 1/2 x 1 1/4 65 x 32	2 1/2 64	1.0 0.5	4 x 1 100 x 25	3 C 76	2.2 1.0	5 x 3 125 x 80	3 1/2 89	4.4 2.0	8 x 3 200 x 80	5 127	12.0 5.5
2 1/2 x 1 1/2 65 x 40	2 1/2 64	1.3 0.6	4 x 1 1/4 100 x 32	3 76	2.2 1.0	5 x 4 125 x 100	3 1/2 C 89	4.5 2.0	8 x 4 200 x 100	5 C 127	9.0 4.1

## Grooved Fittings

**FIG. 7072, CONT'D.**

GR x GR CONCENTRIC REDUCERS



**FIGURE 7072 CONCENTRIC REDUCER (CONTINUED FROM PREVIOUS PAGE)**

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
8 x 5	5	11.5
200 x 125	127	5.2
8 x 6	5 C	10.6
200 x 150	127	4.8
10 x 4	6	20
250 x 100	152	9.1
10 x 5	6	20
250 x 125	152	9.1
10 x 6	6 C	20
250 x 150	152	9.1
10 x 8	6	23.9
250 x 200	152	10.8
12 x 4	7	25
300 x 100	178	11.3
12 x 6	7	29
300 x 150	178	13.2
12 x 8	7	29
300 x 200	178	13.2

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
12 x 10	7	32.4
300 x 250	178	14.7
14 x 6	13	54.3
350 x 150	330	24.6
14 x 8	13	54.5
350 x 200	330	24.7
14 x 10	13	55.7
350 x 250	330	25.3
14 x 12	13	57.3
350 x 300	330	26.0
16 x 8	14	65.4
400 x 200	356	29.7
16 x 10	14	66.7
400 x 250	356	30.3
16 x 12	14	68.1
400 x 300	356	30.9
16 x 14	14	71.0
400 x 350	356	32.2

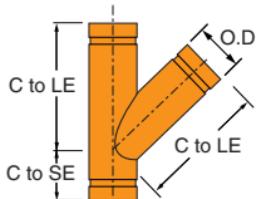
Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
18 x 10	15	82.3
450 x 250	381	37.3
18 x 12	15	83.6
450 x 300	381	37.9
18 x 14	15	86.2
450 x 350	381	39.1
18 x 16	15	87.2
450 x 400	381	39.6
20 x 10	20	123.0
500 x 250	508	55.8
20 x 12	20	125.0
500 x 300	508	56.7
20 x 14	20	129.0
500 x 350	508	58.5
20 x 16	20	131.0
500 x 400	508	59.4
20 x 18	20	133.0
500 x 450	508	60.3

Nominal Size	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
24 x 10	20	147.0
600 x 250	508	66.7
24 x 12	20	149.0
600 x 300	508	67.6
24 x 14	20	152.0
600 x 350	508	68.9
24 x 16	20	153.0
600 x 400	508	69.4
24 x 18	20	154.0
600 x 450	508	69.9
24 x 20	20	155.0
600 x 500	508	70.3

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7069**

45° LATERAL

**FIGURE 7069 45° LATERALS**

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	5	2 1/4	1.5
25	33.4	127	57	0.7
1 1/4	1.660	5 3/4	2 1/2	2.5
32	42.2	146	64	1.1
1 1/2	1.900	6 1/4	2 3/4	3.5
40	48.3	159	70	1.6
2	2.375	7	2 3/4	4.5
50	60.3	178	70	2.0
2 1/2	2.875	7 3/4	3	10.0
65	73.0	197	76	4.5
3	3.500	8 1/2	3 1/4	11.0
80	88.9	216	83	5.0
3 1/2	4.000	10	3 1/2	14.0
90	101.6	254	89	6.4

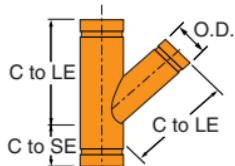
Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
4	4.500	10 1/2	3 3/4	18.3
100	114.3	267	95	8.3
5	5.563	12 1/2	4	30.0
125	141.3	318	102	13.6
6	6.625	14	4 1/2	46.6
150	168.3	356	114	21.1
8	8.625	18	6	82.8
200	219.1	457	152	37.6
10	10.750	20 1/2	6 1/2	127
250	273.1	521	165	57.4
12	12.750	23	7	165
300	323.9	584	178	74.8
14	14.000	26 1/2	7 1/2	215
350	355.6	673	191	97.5

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
16	16.000	29	8	345
400	406.4	737	203	157
18	18.000	32	8 1/2	425
450	457.2	813	216	193
20	20.000	35	9	517
500	508.0	889	229	235
24	24.000	40	10	940
600	609.6	1016	254	426

## Grooved Fittings

**FIG. 7070**

45° REDUCING LATERAL



**FIGURE 7070 45° REDUCING LATERAL**

Nominal Size	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
3 x 3 x 2	8½	3¼	9.8
80 x 80 x 50	216	83	4.4
3 x 3 x 2½	8½	3¼	11.5
80 x 80 x 65	216	83	5.2
4 x 4 x 2	10½	3¾	15.5
100 x 100 x 50	267	95	7.0
4 x 4 x 2½	10½	3¾	17.0
100 x 100 x 65	267	95	7.7
4 x 4 x 3	10½	3¾	18.5
100 x 100 x 80	267	95	8.4
5 x 5 x 2	12½	4	22.5
125 x 125 x 50	318	102	10.2
5 x 5 x 3	12½	4	26.5
125 x 125 x 80	318	102	12.0
5 x 5 x 4	12½	4	30.5
125 x 125 x 100	318	102	13.8

Nominal Size	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
6 x 6 x 2	14	4½	33.0
150 x 150 x 50	356	114	15.0
6 x 6 x 3	14	4½	37.0
150 x 150 x 80	356	114	16.8
6 x 6 x 4	14	4½	40.0
150 x 150 x 100	356	114	18.1
6 x 6 x 5	14	4½	45.0
150 x 150 x 125	356	114	20.4
8 x 8 x 4	18	6	59.6
200 x 200 x 100	457	152	27.0
8 x 8 x 5	18	6	68.0
200 x 200 x 125	457	152	30.8
8 x 8 x 6	18	6	75.0
200 x 200 x 150	457	152	34.0
10 x 10 x 4	20½	6½	83.0
250 x 250 x 100	521	165	37.6

Nominal Size	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10 x 10 x 5	20½	6½	100.0
250 x 250 x 125	521	165	45.4
10 x 10 x 6	20½	6½	105.0
250 x 250 x 150	521	165	47.6
10 x 10 x 8	20½	6½	116.0
250 x 250 x 200	521	165	52.6
12 x 12 x 4	23	7	137.0
300 x 300 x 100	584	178	62.1
12 x 12 x 6	23	7	140.0
300 x 300 x 150	584	178	63.5
12 x 12 x 8	23	7	147.0
300 x 300 x 200	584	178	66.7
12 x 12 x 10	23	7	168
300 x 300 x 250	584	178	76.2
14 x 14 x 4	26½	7½	173
350 x 350 x 100	673	191	78.5

**FIG. 7070, CONT'D.**

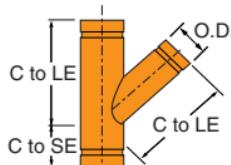
45° REDUCING LATERAL

**FIGURE 7070 45° REDUCING LATERAL**

Nominal Size <i>In./DN(mm)</i>	Center to Long End <i>In./mm</i>	Center to Short End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
14 x 14 x 6 350 x 350 x 150	26½ 673	7½ 191	185 83.9
14 x 14 x 8 350 x 350 x 200	26½ 673	7½ 191	195 88.5
14 x 14 x 10 350 x 350 x 250	26½ 673	7½ 191	223 101
14 x 14 x 12 350 x 350 x 300	26½ 673	7½ 191	240 109
16 x 16 x 6 400 x 400 x 150	29 737	8 203	235 107
16 x 16 x 8 400 x 400 x 200	29 737	8 203	250 113
16 x 16 x 10 400 x 400 x 250	29 737	8 203	263 119
16 x 16 x 12 400 x 400 x 300	29 737	8 203	283 128
16 x 16 x 14 400 x 400 x 350	29 737	8 203	307 139
18 x 18 x 6 450 x 450 x 150	32 813	8½ 216	275 125

Nominal Size <i>In./DN(mm)</i>	Center to Long End <i>In./mm</i>	Center to Short End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
18 x 18 x 8 450 x 450 x 200	32 813	8½ 216	306 139
18 x 18 x 10 450 x 450 x 250	32 813	8½ 216	321 146
18 x 18 x 12 450 x 450 x 300	32 813	8½ 216	333 151
18 x 18 x 14 450 x 450 x 350	32 813	8½ 216	358 162
18 x 18 x 16 450 x 450 x 400	32 813	8½ 216	382 173
20 x 20 x 12 500 x 500 x 300	35 889	9 229	390 177
20 x 20 x 14 500 x 500 x 350	35 889	9 229	410 186
20 x 20 x 16 500 x 500 x 400	235 889	9 229	440 200
24 x 24 x 16 600 x 600 x 400	40 1016	10 254	725 329
24 x 24 x 20 600 x 600 x 500	40 1016	10 254	785 356

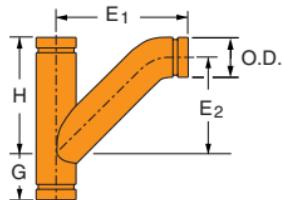
See Fitting Size Chart on page 148 for O.D. sizes



## Grooved Fittings

**FIG. 7066**

TEE WYE



**FIGURE 7066 TEE WYE (CONTINUED ON NEXT PAGE)**

Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
2 x 2 x 2 50 x 50 x 50	2 $\frac{3}{4}$ 70	7 178	9 229	4 $\frac{1}{2}$ 117	6.4 2.9
2 $\frac{1}{2}$ x 2 $\frac{1}{2}$ x 2 $\frac{1}{2}$ 65 x 65 x 65	3 76	7 $\frac{3}{4}$ 197	10 $\frac{1}{2}$ 267	5 $\frac{1}{4}$ 146	11.5 5.2
3 x 3 x 3 80 x 80 x 80	3 $\frac{1}{4}$ 83	8 $\frac{1}{2}$ 216	11 $\frac{1}{2}$ 292	6 $\frac{1}{2}$ 165	16.5 7.5
3 $\frac{1}{2}$ x 3 $\frac{1}{2}$ x 3 $\frac{1}{2}$ 90 x 90 x 90	3 $\frac{1}{2}$ 89	10 254	13 330	7 $\frac{3}{4}$ 197	22 10.0
4 x 4 x 3 100 x 100 x 80	3 $\frac{3}{4}$ 95	10 $\frac{1}{2}$ 267	12 $\frac{1}{8}$ 327	7 $\frac{1}{8}$ 200	23 10.4
4 x 4 x 4 100 x 100 x 100	3 $\frac{3}{4}$ 95	10 $\frac{1}{2}$ 267	13 $\frac{1}{8}$ 346	8 $\frac{1}{8}$ 206	26 11.8
5 x 5 x 3 125 x 125 x 80	4 102	12 $\frac{1}{2}$ 318	14 $\frac{1}{4}$ 362	9 $\frac{1}{4}$ 235	32 14.5
5 x 5 x 4 125 x 125 x 100	4 102	12 $\frac{1}{2}$ 318	15 $\frac{1}{8}$ 384	9 $\frac{5}{8}$ 244	35 15.9

Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
5 x 5 x 5 125 x 125 x 125	4 102	12 $\frac{1}{2}$ 318	16 $\frac{1}{8}$ 410	10 254	40 18.1
6 x 6 x 3 150 x 150 x 80	4 $\frac{1}{2}$ 114	14 356	15 $\frac{5}{16}$ 389	10 $\frac{5}{16}$ 262	50 22.7
6 x 6 x 4 150 x 150 x 100	4 $\frac{1}{2}$ 114	14 356	16 $\frac{1}{4}$ 413	10 $\frac{3}{4}$ 273	55 24.9
6 x 6 x 5 150 x 150 x 125	4 $\frac{1}{2}$ 114	14 356	17 $\frac{1}{4}$ 438	11 $\frac{1}{8}$ 283	58 26.3
6 x 6 x 6 150 x 150 x 150	4 $\frac{1}{2}$ 114	14 356	18 $\frac{1}{4}$ 464	11 $\frac{1}{2}$ 292	60.5 27.4
8 x 8 x 3 200 x 200 x 80	6 152	18 457	18 $\frac{3}{16}$ 462	13 $\frac{3}{16}$ 338	100 45.4
8 x 8 x 4 200 x 200 x 100	6 152	18 457	19 483	13 $\frac{1}{2}$ 343	110 49.9
8 x 8 x 5 200 x 200 x 125	6 152	18 457	20 508	13 $\frac{7}{8}$ 352	111 50.3

FIG. 7066, CONT'D.

TEE WYE

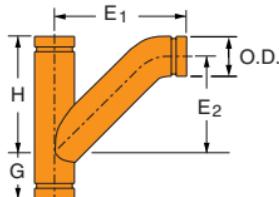


FIGURE 7066 TEE WYE (CONTINUED FROM PREVIOUS PAGE)

Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
8 x 8 x 6 200 x 200 x 150	6 152	18 457	21½ 537	14¾ 365	112 50.8
8 x 8 x 8 200 x 200 x 200	6 152	18 457	23¼ 591	15¼ 387	120 54.4
10 x 10 x 3 250 x 250 x 80	6½ 165	20½ 521	19¾ 505	14¾ 378	130 59.0
10 x 10 x 4 250 x 250 x 100	6½ 165	20½ 521	20¾ 527	15¼ 387	135 61.2
10 x 10 x 5 250 x 250 x 125	6½ 165	20½ 521	21¾ 556	15¾ 400	140 63.5
10 x 10 x 6 250 x 250 x 150	6½ 165	20½ 521	22¾ 581	16¾ 410	145 65.8
10 x 10 x 8 250 x 250 x 200	6½ 165	20½ 521	27¼ 692	19¼ 489	150 68.0
10 x 10 x 10 250 x 250 x 250	6½ 165	20½ 521	27¼ 692	18 457	190 86.2

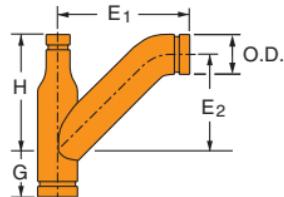
Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
12 x 12 x 3 300 x 300 x 80	7 178	23 584	20¾ 527	15¾ 400	140 63.5
12 x 12 x 4 300 x 300 x 100	7 178	23 584	21½ 546	16 406	145 65.8
12 x 12 x 6 300 x 300 x 150	7 178	23 584	23¾ 603	17 432	165 74.8
12 x 12 x 8 300 x 300 x 200	7 178	23 584	26 660	18 457	175 79.4
12 x 12 x 10 300 x 300 x 250	7 178	23 584	28 711	18¾ 476	200 90.7
12 x 12 x 12 300 x 300 x 300	7 178	23 584	31 787	20½ 521	240 109

See Fitting Size Chart on page 148 for O.D. sizes

## Grooved Fittings

**FIG. 7067**

REDUCING TEE WYE



**FIGURE 7067 REDUCING TEE WYE**

Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
4 x 3 x 3	1 1/8	7 1/8	10 1/4	5 5/8	16.0
100 x 80 x 80	41	187	273	143	7.3
4 x 3 x 4	3 3/4	10 1/2	13 1/8	8 1/8	27.0
100 x 80 x 100	95	267	346	206	12.2
5 x 3 x 3	1 1/4	9 3/4	11 1/2	6 1/2	25.0
125 x 80 x 80	32	248	292	165	11.3
5 x 3 x 5	4	12 1/2	16 1/8	10	44.0
125 x 80 x 125	102	318	410	254	20.0
5 x 4 x 3	1 1/8	9 1/8	11 1/8	6 1/8	21.0
125 x 100 x 80	48	232	302	175	9.5
5 x 4 x 4	1 1/8	9 1/8	12 3/4	7 1/4	25.0
125 x 100 x 100	48	232	324	184	11.3

Nominal Size	G	H	E1	E2	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
6 x 4 x 6	4 1/2	14	18 1/4	11 1/2	61.0
150 x 100 x 150	114	356	464	292	27.7
6 x 5 x 3	1 1/4	10 1/4	13	8	27.0
150 x 125 x 80	32	273	330	203	12.2
6 x 5 x 4	1 1/4	10 1/4	13 7/8	8 3/8	31.0
150 x 125 x 100	32	273	352	213	14.1
8 x 6 x 4	1	12	14 1/4	9 1/4	45.0
200 x 150 x 100	25	305	375	235	20.4
8 x 6 x 8	6	18	23 1/4	15 1/4	95.0
200 x 150 x 200	152	457	591	387	43.1

See Fitting Size Chart on page 148 for O.D. sizes

FIG. 7071

TRUE WYE

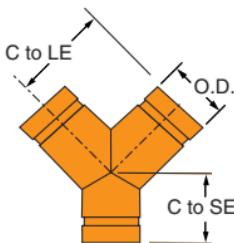


FIGURE 7071 TRUE WYE

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	2 $\frac{1}{4}$	2 $\frac{1}{4}$	1.1
25	33.4	57	57	0.5
1 $\frac{1}{4}$	1.660	2 $\frac{3}{4}$	2 $\frac{1}{2}$	1.5
32	42.2	70	64	0.7
1 $\frac{1}{2}$	1.900	2 $\frac{3}{4}$	2 $\frac{3}{4}$	1.8
40	48.3	70	70	0.8
2	2.375	3 $\frac{1}{4}$	2 $\frac{3}{4}$	2.3
50	60.3	83	70	1.0
2 $\frac{1}{2}$	2.875	3 $\frac{3}{4}$	3	5.0
65	73.0	95	76	2.3
3	3.500	4 $\frac{1}{4}$	3 $\frac{1}{4}$	6.1
80	88.9	108	83	2.8

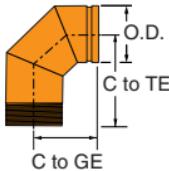
Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
3 $\frac{1}{2}$	4.000	4 $\frac{1}{2}$	3 $\frac{1}{2}$	8.3
90	101.6	114	89	3.8
4	4.500	5	3 $\frac{3}{4}$	10.5
100	114.3	127	95	4.8
5	5.563	5 $\frac{1}{2}$	4	15
125	141.3	140	102	6.8
6	6.625	6 $\frac{1}{2}$	4 $\frac{1}{2}$	21.6
150	168.3	165	114	9.8
8	8.625	7 $\frac{1}{4}$	6	36.0
200	219.1	197	152	16.3
10	10.750	9	6 $\frac{1}{2}$	51.0
250	273.1	229	165	23.1

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
12	12.750	10	7	160.0
300	323.9	254	178	72.6
14	14.000	11	7 $\frac{1}{2}$	136.0
350	355.6	279	191	61.7
16	16.000	12	8	166.0
400	406.4	305	203	75.3
18	18.000	15 $\frac{1}{2}$	8 $\frac{1}{2}$	234
450	457.2	394	216	106
20	20.000	17 $\frac{1}{4}$	9	281
500	508.0	438	229	128
24	24.000	20	10	523
600	609.6	508	254	237

## Grooved Fittings

**FIG. 7055 GR x MPT**

90° ADAPTER ELBOW

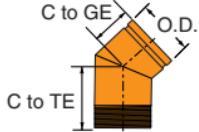


**FIGURE 7055 90° ADAPTER ELBOWS**

Nominal Size	O.D.	Center to Grooved End	Center to Threaded End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	2 1/4	2 1/4	0.6
25	33.4	57	57	0.3
1 1/4	1.660	2 3/4	2 3/4	1.0
32	42.2	70	70	0.5
1 1/2	1.900	2 3/4	2 3/4	1.2
40	48.3	70	70	0.5
2	2.375	3 1/4	4 1/4	2.3
50	60.3	83	108	1.0
2 1/2	2.875	3 3/4	3 3/4	3.7
65	73.0	95	95	1.7
3	3.500	4 1/4	6	6.5
80	88.9	108	152	2.9
3 1/2	4.000	4 1/2	6 1/4	8.2
90	101.6	114	159	3.7
4	4.500	5	7 1/4	11
100	114.3	127	184	5.0
6	6.625	6 1/2	6 1/2	19.8
150	168.3	165	165	9.0

**FIG. 7056 GR x MPT**

45° ADAPTER ELBOW

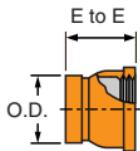


**FIGURE 7056 45° ADAPTER ELBOWS**

Nominal Size	O.D.	Center to Grooved End	Center to Threaded End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	1 3/4	1 3/4	0.6
25	33.4	44	44	0.3
1 1/4	1.660	1 3/4	1 3/4	0.7
32	42.2	44	44	0.3
1 1/2	1.900	1 3/4	1 3/4	0.8
40	48.3	44	44	0.4
2	2.375	2	3	1.6
50	60.3	51	76	0.7
2 1/2	2.875	2 1/4	2 1/4	2.2
65	73.0	57	57	1.0
3	3.500	2 1/2	4 1/4	4.3
80	88.9	64	108	2.0
3 1/2	4.000	2 3/4	2 3/4	4.2
90	101.6	70	70	1.9
4	4.500	3	5 1/4	7.5
100	114.3	76	133	3.4
6	6.625	3 1/2	3 1/2	11.1
150	168.3	89	89	5.0

**FIG. 7087 GR x FPT**

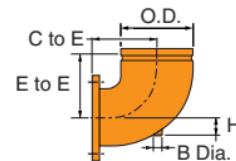
FEMALE THREAD ADAPTER

**FIGURE 7087 FEMALE THREAD ADAPTER**

Nominal Size	Grooved End O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	2 $\frac{1}{16}$	0.7
25	33.4	52	0.3
1 $\frac{1}{4}$	1.660	2 $\frac{5}{16}$	1.4
32	42.2	59	0.6
1 $\frac{1}{2}$	1.900	2 $\frac{5}{16}$	1.5
40	48.3	59	0.7
2	2.375	2 $\frac{1}{2}$	1.6
50	60.3	64	0.7
3	3.500	2 $\frac{3}{4}$	2.5
80	88.9	70	1.1
4	4.500	3 $\frac{1}{4}$	4.5
100	114.3	83	2.0

**FIG. 7050RF**

GROOVED X 150# FLANGED (GxF)

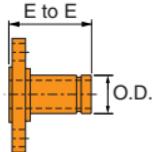
**FIGURE 7050 RF REDUCING BASE SUPPORT ELBOWS**

Nominal Size	Grooved End O.D.	Center to End	H	B Dia. Threaded	Approx. Wt. Ea. GxF
In./DN(mm)	In./mm	In./mm	In./mm	NPSC	Lbs./Kg
6 x 4	6.625	12	2 $\frac{1}{2}$	1 $\frac{1}{2}$	38.5
150 x 100	168.3	305	64	38	17.5
6 x 5	6.625	12 $\frac{1}{2}$	2 $\frac{1}{2}$	1 $\frac{1}{2}$	45.4
150 x 125	168.3	318	64	38	20.6
8 x 5	8.625	16	3	1 $\frac{1}{2}$	65.5
200 x 125	219.1	406	76	38	29.7
8 x 6	8.625	16	3	1 $\frac{1}{2}$	73
200 x 150	219.1	406	76	38	33.1
10 x 6	10.750	19	3 $\frac{1}{2}$	1 $\frac{1}{2}$	100
250 x 150	273.1	483	89	38	45.4
10 x 8	10.750	19	3 $\frac{1}{2}$	1 $\frac{1}{2}$	127
250 x 200	273.1	483	89	38	57.6
12 x 8	12.750	22	4	1 $\frac{1}{2}$	155
300 x 200	323.9	559	102	38	70.3
12 x 10	12.750	22	4	1 $\frac{1}{2}$	186
300 x 250	323.9	559	102	38	84.4

## Grooved Fittings

**FIG. 7084**

GROOVE X CLASS 150  
FLANGE NIPPLES



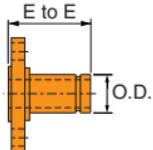
\* Contact a Anvil Representative for dimensions & weights.

**FIGURE 7084 GROOVE X CLASS 150 FLANGE NIPPLES**

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	3	2.5
25	33.4	76	1.1
1 1/4	1.660	4	3.8
32	42.2	102	1.7
1 1/2	1.900	4	4.1
40	48.3	102	1.9
2	2.375	4	6.0
50	60.3	102	2.7
2 1/2	2.875	4	9.2
65	73.0	102	4.2
3	3.500	4	10.4
80	88.9	102	4.7
3 1/2	4.000	4	14.0
90	101.6	102	6.4
4	4.500	6	19.1
100	114.3	152	8.7
5	5.563	6	23.0
125	141.3	152	10.4

**FIG. 7085**

GROOVE X CLASS 300  
FLANGE NIPPLES



**FIGURE 7085 GROOVE X CLASS 300 FLANGE NIPPLES**

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
6	6.625	6	29.5
150	168.3	152	13.4
8	8.625	6	43.5
200	219.1	152	19.7
10	10.750	8	68.2
250	273.1	203	30.9
12	12.750	8	96.1
300	323.9	203	43.6
14	14.000	*	*
350	355.6	*	*
16	16.000	*	*
400	406.4	*	*
18	18.000	*	*
450	457.2	*	*
20	20.000	*	*
500	508.0	*	*
24	24.000	*	*
600	609.6	*	*

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
6	6.625	6	35.0
150	168.3	152	15.9
8	8.625	6	50.0
200	219.1	152	22.7
10	10.750	6	72.0
250	273.1	152	32.7
12	12.750	8	*
300	323.9	203	*
14	14.000	8	*
350	355.6	203	*
16	16.000	*	*
400	406.4	*	*
18	18.000	*	*
450	457.2	*	*
20	20.000	*	*
500	508.0	*	*
24	24.000	*	*
600	609.6	*	*

FIG. 7074

CAP

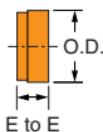


FIGURE 7074 CAP

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	1 1/4	0.3
25	33.4	32	0.1
1 1/4 C	1.660	1 1/4	0.4
32	42.2	32	0.2
1 1/2 C	1.900	1 1/4	0.5
40	48.3	32	0.2
2 C	2.375	1	0.5
50	60.3	25	0.2
2 1/2 C	2.875	1	0.7
65	73.0	25	0.3
3 O.D. C	2.996	1	0.8
76.1	76.1	25	0.4
3 C	3.500	1	1.1
80	88.9	25	0.5
3 1/2 C	4.000	1	1.4
90	101.6	25	0.6
4 1/4 O.D. C	4.250	1 1/8	2.0
108.0	108.0	29	0.9

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
4 C	4.500	1 1/8	2.8
100	114.3	29	1.3
5 1/4 O.D. C	5.236	1 1/8	3.2
133.0	133.0	29	1.5
5 1/2 O.D. C	5.500	1 1/8	4.0
139.7	139.7	29	1.8
5 C	5.563	1 1/8	4.0
125	141.3	29	1.8
6 1/4 O.D. C	6.259	1 1/8	5.1
159.0	159.0	29	2.3
6 1/2 O.D. C	6.500	1 1/8	6.0
165.1	165.1	29	2.7
6 C	6.625	1 9/16	6.0
150	168.3	33	2.7
8 C	8.625	1 1/2	12.5
200	219.1	38	5.7
10 C	10.750	1 1/2	21.9
250	273.1	38	9.9

Nominal Size	O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
12 C	12.750	1 1/2	33.8
300	323.9	38	15.3
14*	14.000	8 1/2	40
350	355.6	216	18.1
16*	16.000	9	45
400	406.4	229	20.4
18*	18.000	10	58
450	457.2	254	26.3
20*	20.000	11	79
500	508.0	279	35.8
24*	24.000	12 1/2	100
600	609.6	318	45.4

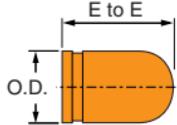
\* Machined Cap

C - Cast Malleable or Ductile Iron

## Grooved Fittings

**FIG. 7075**

BULL PLUG



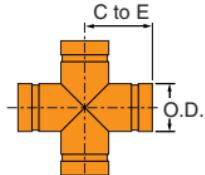
**FIGURE 7075 BULL PLUG**

Nominal Size	Fitting O.D.	End to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4	2.5
50	60.3	102	1.1
2½	2.875	5	3.1
65	73.0	127	1.4
3	3.500	6	4.4
80	88.9	152	2.0
4	4.500	7	7.4
100	114.3	178	3.4
5	5.563	*	*
125	141.3	*	*
6	6.625	10	18.5
150	168.3	254	8.4

\* Contact a Anvil Representative for dimensions & weights.

**FIG. 7068**

CROSS



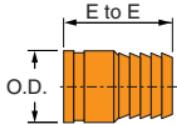
**FIGURE 7068 CROSS**

Nominal Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1	1.315	2¼	1.3
25	33.4	57	0.6
1¼	1.660	2¾	2.1
32	42.2	70	1.0
1½	1.900	2¾	2.5
40	48.3	70	1.1
2	2.375	3¼	2.9
50	60.3	83	1.3
2½	2.875	3¾	5.2
65	73.0	95	2.4
3	3.500	4¼	7.5
80	88.9	108	3.4
3½	4.000	4½	9.8
90	101.6	114	4.4
4	4.500	5	12.2
100	114.3	127	5.5
5	5.563	5½	17.6
125	141.3	140	8.0

Nominal Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
6	6.625	6½	28.3
150	168.3	165	12.8
8	8.625	7¾	48.0
200	219.1	197	21.8
10	10.750	9	70.0
250	273.1	229	31.8
12	12.750	10	110
300	323.9	254	49.9
14	14.000	11	140
350	355.6	279	63.5
16	16.000	12	170
400	406.4	305	77.1
18	18.000	15½	260
450	457.2	394	118
20	20.000	17¼	320
500	508.0	438	145
24	24.000	20	585
600	609.6	508	265

**FIG. 7086**

GR x HOSE NIPPLES

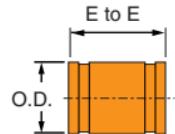
**FIGURE 7086 HOSE NIPPLES**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1	1.315	3 1/4	0.4
25	33.4	83	0.2
1 1/4	1.660	3 5/8	0.7
32	42.2	92	0.3
1 1/2	1.900	4	0.8
40	48.3	102	0.4
2	2.375	4 5/8	1.3
50	60.3	117	0.6
2 1/2	2.875	5 1/2	2.1
65	73.0	140	1.0
3	3.500	6	3.3
80	88.9	152	1.5

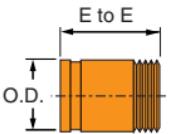
Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4	4.500	7 1/4	5.5
100	114.3	184	2.5
5	5.563	9 3/4	8.1
125	141.3	248	3.7
6	6.625	11	13.2
150	168.3	279	6.0
8	8.625	12 1/2	24.0
200	219.1	318	10.9
10	10.750	14	29.0
250	273.1	356	13.2
12	12.750	16	46.0
300	323.9	406	20.9

**FIG. 7080**

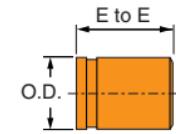
GR x GR

**FIG. 7081**

GR x MPT

**FIG. 7082**

GR x BEV

**FIGURES 7080, 7081 & 7082 ADAPTER NIPPLES**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1	1.315	3	0.4
25	33.4	76	0.2
1 1/4	1.660	4	0.8
32	42.2	102	0.4
1 1/2	1.900	4	0.9
40	48.3	102	0.4
2	2.375	4	1.2
50	60.3	102	0.5
2 1/2	2.875	4	1.9
65	73.0	102	0.9
3	3.500	4	2.5
80	88.9	102	1.1
3 1/2	4.000	4	3.1
90	101.6	102	1.4

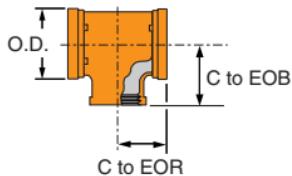
Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4	4.500	6	5.5
100	114.3	152	2.5
5	5.563	6	7.4
125	141.3	152	3.4
6	6.625	6	9.5
150	168.3	152	4.3
8	8.625	6	14.2
200	219.1	152	6.4
10	10.750	8	27.0
250	273.1	203	12.2
12	12.750	8	33.0
300	323.9	203	15.0

This product is not UL/ULC Listed or FM Approved.

## Grooved Fittings

**FIG. 7065**

STANDPIPE TEE (GR x GR x FPT)



**FIGURE 7065 STANDPIPE TEE (GR x GR x FPT)**

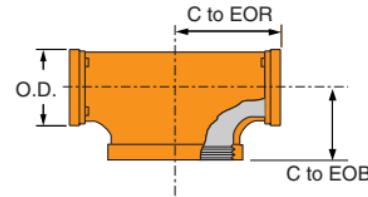
Nominal Size	O.D.	Center to End of Run	Center to End of Branch	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
4 x 4 x 2½	4.500	3¼	4	7.6
100 x 100 x 65	114.3	83	102	3.4
6 x 6 x 2½	6.625	3¼	5½	11.2
150 x 150 x 65	168.3	83	130	5.1

See Fitting Size Chart on page 148 for O.D. sizes.

These fittings are designed to provide minimal pressure drop and uniform strength. Pressure ratings of Gruvlok Fittings conforms to those of Fig. 7001 Gruvlok Standard Coupling.

**FIG. 7062**

BULLHEAD TEE SPECIALTY TEES (GR x GR x FPT)



**FIGURE 7065 STANDPIPE TEE (GR x GR x FPT)**

Nominal Size	O.D.	Center to End of Run	Center to End of Branch	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
5 x 5 x 8	7¾	5½	31.0	7.6
125 x 125 x 200	197	140	14.1	3.4
6 x 6 x 8	7¾	6½	37.6	11.2
150 x 150 x 200	197	165	17.1	5.1

See Fitting Size Chart on page 148 for O.D. sizes.

These fittings are designed to provide minimal pressure drop and uniform strength. Pressure ratings of Gruvlok Fittings conforms to those of Fig. 7001 Gruvlok Standard Coupling.

**FIG. 7050DR**

STANDPIPE TEE (GR x GR x FPT)

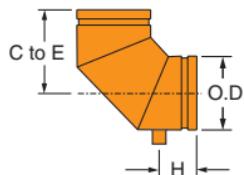


FIGURE 7050DR 90° DRAIN ELBOW

Nominal Size	O.D.	Max Working Pressure	Dimensions		Approx. Wt. Ea.
			C to E	H	
In./DN(mm)	In./mm	psi/bar	In./mm	In./mm	Lbs./Kg
1/4	1.660	300	2 3/4	1 3/4	0.70
32	42.2	20.7	69	44	0.30
1 1/2	1.900	300	2 3/4	1 3/4	1.70
40	48.3	20.7	69	44	0.8
2	2.375	300	3 1/4	1 3/4	2.00
50	60.3	20.7	83	44	0.90
2 1/2	2.875	300	3 3/4	1 7/8	2.50
65	73.0	20.7	95	48	1.10
3	3.500	300	4 1/4	2	3.20
80	88.9	20.7	108	51	1.50
4	4.500	300	5	2 1/4	4.60
100	114.3	20.7	127	57	2.10

Nominal Size	O.D.	Max Working Pressure	Dimensions		Approx. Wt. Ea.
			C to E	H	
In./DN(mm)	In./mm	psi/bar	In./mm	In./mm	Lbs./Kg
5	5.583	300	5 1/2	2 3/8	11.5
125	141.3	20.7	140	60	5.2
6	6.625	300	6 1/2	2 3/8	9.60
150	168.3	20.7	165	60	4.40
8	8.625	300	7 3/4	2 1/2	15.8
200	219.1	20.7	197	64	7.20
10	10.750	300	9	2 3/4	48.5
250	273.1	20.7	229	69	22.0
12	12.750	300	10	2 3/4	66.0
300	323.9	20.7	254	69	29.0

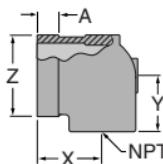
Available fabricated Schedule 10 only.

Drain elbow has a standard 1" female NPT outlet

## Grooved Fittings

**FIG. 7091**

END-OF-LINE FITTING



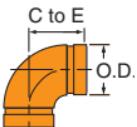
**FIGURE 7091 END-OF-LINE FITTING**

Nominal Size Run x Branch	O.D.	Max. Wk. Pressure	Coupling Dimensions			Approx. Wt. Ea.
			A	X	Y	
In./DN(mm)	In./mm	PSI/bar	In./mm	In./mm	In./mm	Lbs./kg
1½ x ½	1.900	300	5/8	1¾	1⁹/₁₆	0.8
40 x 15	48	20.7	16	44	33	0.3
1½ x ¾	1.900	300	5/8	1¾	1⁹/₁₆	0.8
40 x 20	48	20.7	16	44	33	0.3
1½ x 1	1.900	300	5/8	1⅞	1⅓	0.8
40 x 25	48	20.7	16	48	35	0.3
2 x ½	2.375	300	5/8	1¾	1⁹/₁₆	1.0
50 x 15	60	20.7	16	44	40	0.4
2 x ¾	2.375	300	5/8	1¾	1⁹/₁₆	1.0
50 x 20	60	20.7	16	44	40	0.4

Nominal Size Run x Branch	O.D.	Max. Wk. Pressure	Coupling Dimensions			Approx. Wt. Ea.
			A	X	Y	
In./DN(mm)	In./mm	PSI/bar	In./mm	In./mm	In./mm	Lbs./kg
2 x 1	2.375	300	5/8	1⅞	1⅞	1.0
50 x 25	60	20.7	16	48	41	0.4
2½ x ½	2.875	300	5/8	1¾	1¾	1.4
65 x 15	73	20.7	16	44	44	0.6
2½ x ¾	2.875	300	5/8	1¾	1¾	1.4
65 x 20	73	20.7	16	44	44	0.6
2½ x 1	2.875	300	5/8	1⅞	1¹³/₁₆	1.4
65 x 25	73	20.7	16	48	46	0.6

**FIG. 7450**

90° SHORT PATTERN ELBOW

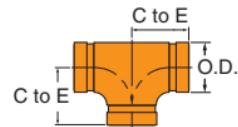
**FIGURE 7450 90° ELBOW**

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	2 $\frac{1}{4}$	1.7
50	60.3	70	0.8
2 $\frac{1}{2}$	2.875	3	2.6
65	73.0	76	1.2
3	3.500	3 $\frac{1}{8}$	3.5
80	88.9	86	1.6
4	4.500	4	6.5
100	114.3	102	3.0
6	6.625	5 $\frac{1}{2}$	14.8
150	168.3	140	6.7
8	8.625	6 $\frac{1}{8}$	25.6
200	219.1	175	11.6

See the Gruvlok Catalog for additional information

**FIG. 7460**

SHORT PATTERN TEE

**FIGURE 7460 TEE**

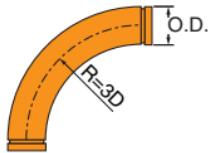
Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	2 $\frac{1}{4}$	2.5
50	60.3	70	1.1
2 $\frac{1}{2}$	2.875	3	3.5
65	73.0	76	1.6
3	3.500	3 $\frac{1}{8}$	4.8
80	88.9	86	2.2
4	4.500	4	8.1
100	114.3	102	3.7
6	6.625	5 $\frac{1}{2}$	19.1
150	168.3	140	8.7
8	8.625	6 $\frac{1}{8}$	35.2
200	219.1	175	16.0

See the Gruvlok Catalog for additional information

## Grooved Fittings

**FIG. 7050 3D**

LONG RADIUS 90° ELBOW

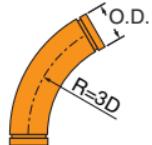


**FIGURE 7050-3D 90° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	10	5.3
50	60.3	254	2.4
2½	2.875	11½	9.5
65	73	292	4.3
3	3.500	13	14.0
80	88.9	330	6.4
3½	4.000	14½	18.6
90	101.6	368	8.4
4	4.500	16	24.1
100	114.3	406	10.9
5	5.563	20	40.9
125	141.3	508	18.6
6	6.625	24	63.7
150	168.3	610	28.9
8	8.625	32	127.8
200	219.1	813	58.0

**FIG. 7057 3D**

LONG RADIUS 60° ELBOW



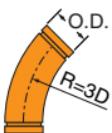
**FIGURE 7057-3D 60° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	40	226.4
250	273.1	1016	102.7
12	12.750	48	332.7
300	323.9	1219	150.9
14	14.000	56	427.3
350	355.6	1422	193.8
16	16.000	64	560.1
400	406.4	1626	254.1
18	18.000	72	710.7
450	457.2	1829	322.4
20	20.000	80	879.3
500	508	2032	398.8
24	24.000	96	1270.3
600	609.6	2438	576.2

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	27½	173.4
250	273.1	692	78.7
12	12.750	32¾	254.8
300	323.9	832	115.6
14	14.000	38¼	327.3
350	355.6	972	148.5
16	16.000	43¾	429.0
400	406.4	1111	194.6
18	18.000	49¼	544.4
450	457.2	1251	246.9
20	20.000	54¾	673.5
500	508	1391	305.5
24	24.000	65½	973.0
600	609.6	1664	441.3

**FIG. 7051 3D**

LONG RADIUS 45° ELBOW

**FIGURE 7051-3D 45° ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	6½	3.9
50	60.3	165	1.8
2½	2.875	7¼	6.7
65	73	184	3.0
3	3.500	7¾	9.5
80	88.9	197	4.3
3½	4.000	8½	12.3
90	101.6	216	5.6
4	4.500	9	15.7
100	114.3	229	7.1
5	5.563	11¼	26.5
125	141.3	286	12.0
6	6.625	13½	41.3
150	168.3	343	18.7
8	8.625	18	82.9
200	219.1	457	37.6

**FIG. 7058 3D**

LONG RADIUS 30° ELBOW

**FIGURE 7058-3D 30° ELBOW**

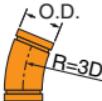
Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	5¾	3.4
50	60.3	146	1.5
2½	2.875	6	5.8
65	73	152	2.6
3	3.500	6½	8.0
80	88.9	165	3.6
3½	4.000	6¾	10.2
90	101.6	171	4.6
4	4.500	7¼	12.8
100	114.3	184	5.8
5	5.563	9	21.8
125	141.3	229	9.9
6	6.625	10¾	33.9
150	168.3	273	15.4
8	8.625	14½	68.0
200	219.1	368	30.8

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
10	10.750	18	120.5
250	273.1	457	54.7
12	12.750	21¾	177.0
300	323.9	552	80.3
14	14.000	25¼	227.3
350	355.6	641	103.1
16	16.000	29	297.9
400	406.4	737	135.1
18	18.000	32½	378.1
450	457.2	826	171.5
20	20.000	36	467.8
500	508	914	212.2
6	6.625	10¾	33.9
150	168.3	273	15.4
8	8.625	14½	68.0
200	219.1	368	30.8

## Grooved Fittings

**FIG. 7052 3D**

LONG RADIUS  $22\frac{1}{2}^\circ$  ELBOW

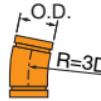


**FIGURE 7052-3D  $22\frac{1}{2}^\circ$  ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	5 $\frac{1}{4}$	3.2
50	60.3	133	1.5
2 $\frac{1}{2}$	2.875	5 $\frac{1}{2}$	5.3
65	73	140	2.4
3	3.500	5 $\frac{3}{4}$	7.3
80	88.9	146	3.3
3 $\frac{1}{2}$	4.000	6	9.2
90	101.6	152	4.2
4	4.500	6 $\frac{1}{2}$	11.4
100	114.3	165	5.2
5	5.563	8	19.4
125	141.3	203	8.8
6	6.625	9 $\frac{1}{2}$	30.1
150	168.3	241	13.7
8	8.625	12 $\frac{3}{4}$	60.5
200	219.1	324	27.4

**FIG. 7053 3D**

LONG RADIUS  $11\frac{1}{4}^\circ$  ELBOW



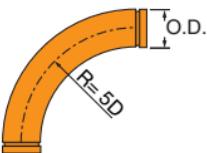
**FIGURE 7053-3D  $11\frac{1}{4}^\circ$  ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4 $\frac{1}{2}$	2.8
50	60.3	114	1.3
2 $\frac{1}{2}$	2.875	4 $\frac{3}{4}$	4.6
65	73	121	2.1
3	3.500	5	6.2
80	88.9	127	2.8
3 $\frac{1}{2}$	4.000	5	7.6
90	101.6	127	3.4
4	4.500	5 $\frac{1}{4}$	9.3
100	114.3	133	4.2
5	5.563	6 $\frac{1}{2}$	15.8
125	141.3	165	7.2
6	6.625	7 $\frac{3}{4}$	24.6
150	168.3	197	11.2
8	8.625	10 $\frac{1}{2}$	49.3
200	219.1	267	22.4

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	13	87.3
250	273.1	330	39.6
12	12.750	15 $\frac{1}{2}$	128.3
300	323.9	394	58.2
14	14.000	18 $\frac{1}{4}$	164.8
350	355.6	464	74.8
16	16.000	20 $\frac{1}{4}$	216.0
400	406.4	527	98.0
18	18.000	23.35	274.1
450	457.2	593	124.3
20	20.000	26	339.2
500	508	660	153.9
24	24.000	31	490.0
600	609.6	787	222.3

**FIG. 7050 5D**

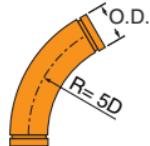
LONG RADIUS 90° ELBOW

**FIGURE 7050-5D 90° ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	14	7.2
50	60.3	356	3.3
2½	2.875	16½	13.3
65	73	419	6.0
3	3.500	19	19.9
80	88.9	483	9.0
3½	4.000	21½	26.9
90	101.6	546	12.2
4	4.500	24	35.4
100	114.3	610	16.1
5	5.563	30	60.0
125	141.3	762	27.2
6	6.625	36	93.5
150	168.3	914	42.4
8	8.625	48	187.6
200	219.1	1219	85.1

**FIG. 7057 5D**

LONG RADIUS 60° ELBOW

**FIGURE 7057-5D 60° ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	9¾	5.6
50	60.3	248	2.5
2½	2.875	11¼	10.2
65	73	286	4.6
3	3.500	12¾	15.0
80	88.9	324	6.8
3½	4.000	12½	20.0
90	101.6	311	9.1
4	4.500	15½	26.0
100	114.3	394	11.8
5	5.563	19½	44.1
125	141.3	495	20.0
6	6.625	23¼	68.6
150	168.3	591	31.1
8	8.625	31	137.7
200	219.1	787	62.5

## Grooved Fittings

**FIG. 7051 5D**

LONG RADIUS 45° ELBOW



**FIGURE 7051-5D 45° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	8 $\frac{1}{4}$	4.8
50	60.3	210	2.2
2 $\frac{1}{2}$	2.875	9 $\frac{1}{4}$	8.6
65	73	235	3.9
3	3.500	10 $\frac{1}{4}$	12.5
80	88.9	260	5.7
3 $\frac{1}{2}$	4.000	11 $\frac{1}{4}$	16.5
90	101.6	286	7.5
4	4.500	12 $\frac{1}{2}$	21.3
100	114.3	318	9.7
5	5.563	15 $\frac{1}{2}$	36.1
125	141.3	394	16.4
6	6.625	18 $\frac{1}{2}$	56.2
150	168.3	470	25.5
8	8.625	24 $\frac{1}{2}$	112.8
200	219.1	622	51.2

**FIG. 7058 5D**

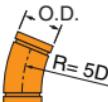
LONG RADIUS 30° ELBOW



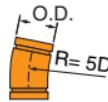
**FIGURE 7058-5D 30° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	30 $\frac{3}{4}$	199.9
250	273.1	781	90.7
12	12.750	37	293.7
300	323.9	940	133.2
14	14.000	43	377.3
350	355.6	1092	171.1
16	16.000	49 $\frac{1}{4}$	494.5
400	406.4	1251	224.3
18	18.000	55 $\frac{1}{4}$	627.6
450	457.2	1403	284.7
20	20.000	61 $\frac{1}{2}$	776.4
500	508	1562	352.2
24	24.000	73 $\frac{3}{4}$	1,121.6
600	609.6	1873	508.7

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	23 $\frac{1}{2}$	155.8
250	273.1	597	70.7
12	12.750	28	228.9
300	323.9	711	103.8
14	14.000	32 $\frac{3}{4}$	294.0
350	355.6	832	133.4
16	16.000	37 $\frac{1}{2}$	385.3
400	406.4	953	174.8
18	18.000	42 $\frac{1}{4}$	489.0
450	457.2	1073	221.8
20	20.000	46 $\frac{3}{4}$	605.0
500	508	1187	274.4
24	24.000	56 $\frac{1}{4}$	873.9
600	609.6	1429	396.4

**FIG. 7052 5D**LONG RADIUS  $22\frac{1}{2}^\circ$  ELBOW**FIGURE 7052-5D  $22\frac{1}{2}^\circ$  ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	6	3.6
50	60.3	152	1.6
$2\frac{1}{2}$	2.875	$6\frac{1}{2}$	6.2
65	73	165	2.8
3	3.500	7	8.8
80	88.9	178	4.0
$3\frac{1}{2}$	4.000	$7\frac{1}{2}$	11.3
90	101.6	191	5.1
4	4.500	8	14.3
100	114.3	203	6.5
5	5.563	10	24.1
125	141.3	254	10.9
6	6.625	12	37.6
150	168.3	305	17.1
8	8.625	16	75.4
200	219.1	406	34.2

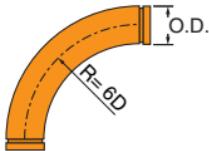
**FIG. 7053 5D**LONG RADIUS  $11\frac{1}{4}^\circ$  ELBOW**FIGURE 7053-5D  $11\frac{1}{4}^\circ$  ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	5	3.0
50	60.3	127	1.4
$2\frac{1}{2}$	2.875	$5\frac{1}{4}$	5.0
65	73	133	2.3
3	3.500	$5\frac{1}{2}$	6.9
80	88.9	140	3.1
$3\frac{1}{2}$	4.000	$5\frac{3}{4}$	8.7
90	101.6	146	3.9
4	4.500	6	10.7
100	114.3	152	4.9
5	5.563	$7\frac{1}{2}$	18.2
125	141.3	191	8.3
6	6.625	9	28.3
150	168.3	229	12.8
8	8.625	12	56.8
200	219.1	305	25.8

## Grooved Fittings

**FIG. 7050 6D**

LONG RADIUS 90° ELBOW

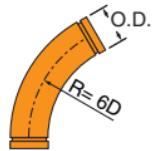


**FIGURE 7050-6D 90° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	16	8.2
50	60.3	406	3.7
2½	2.875	19	15.2
65	73	483	6.9
3	3.500	22	22.9
80	88.9	559	10.4
3½	4.000	25	31.1
90	101.6	635	14.1
4	4.500	28	41.1
100	114.3	711	18.6
5	5.563	35	69.6
125	141.3	889	31.6
6	6.625	42	108.4
150	168.3	1067	49.2
8	8.625	56	217.5
200	219.1	1422	98.7

**FIG. 7057 6D**

LONG RADIUS 60° ELBOW



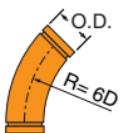
**FIGURE 7057-6D 60° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	70	385.4
250	273.1	1778	174.8
12	12.750	84	566.2
300	323.9	2134	256.8
14	14.000	98	727.4
350	355.6	2489	329.9
16	16.000	112	953.3
400	406.4	2845	432.4
18	18.000	126	1,209.7
450	457.2	3200	548.7
20	20.000	140	1,496.6
500	508	3556	678.8
24	24.000	168	2,162.0
600	609.6	4267	980.7

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	44¾	279.4
250	273.1	1137	126.7
12	12.750	53½	410.5
300	323.9	1359	186.2
14	14.000	62½	527.3
350	355.6	1588	239.2
16	16.000	71½	691.1
400	406.4	1816	313.5
18	18.000	80½	877.1
450	457.2	2045	397.8
20	20.000	89¼	1,085.1
500	508	2267	492.2
24	24.000	107¼	1,567.5
600	609.6	2724	711.0

**FIG. 7051 6D**

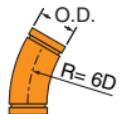
LONG RADIUS 45° ELBOW

**FIGURE 7051-6D 45° ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	9	5.3
50	60.3	229	2.4
2½	2.875	10¼	9.5
65	73	260	4.3
3	3.500	11½	14.0
80	88.9	292	6.4
3½	4.000	12¾	18.6
90	101.6	324	8.4
4	4.500	14	24.1
100	114.3	356	10.9
5	5.563	17½	40.9
125	141.3	445	18.6
6	6.625	21	63.7
150	168.3	533	28.9
8	8.625	28	127.8
200	219.1	711	58.0

**FIG. 7058 6D**

LONG RADIUS 30° ELBOW

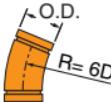
**FIGURE 7058-6D 30° ELBOW**

Nom. Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Center to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2	2.375	7¼	4.3
50	60.3	184	2.0
2½	2.875	8	7.7
65	73	203	3.5
3	3.500	8¾	11.0
80	88.9	222	5.0
3½	4.000	9¾	14.4
90	101.6	248	6.5
4	4.500	10½	18.5
100	114.3	267	8.4
5	5.563	13	31.3
125	141.3	330	14.2
6	6.625	15¾	48.8
150	168.3	400	22.1
8	8.625	21	97.9
200	219.1	533	44.4

## Grooved Fittings

**FIG. 7052 6D**

LONG RADIUS  $22\frac{1}{2}^\circ$  ELBOW

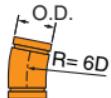


**FIGURE 7052-6D  $22\frac{1}{2}^\circ$  ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	6 1/2	3.9
50	60.3	165	1.8
2 1/2	2.875	7	6.7
65	73	178	3.0
3	3.500	7 1/2	9.5
80	88.9	191	4.3
3 1/2	4.000	8 1/4	12.3
90	101.6	210	5.6
4	4.500	8 3/4	15.7
100	114.3	222	7.1
5	5.563	11	26.5
125	141.3	279	12.0
6	6.625	13 1/4	41.3
150	168.3	337	18.7
8	8.625	17 1/2	82.9
200	219.1	445	37.6

**FIG. 7053 6D**

LONG RADIUS  $11\frac{1}{4}^\circ$  ELBOW



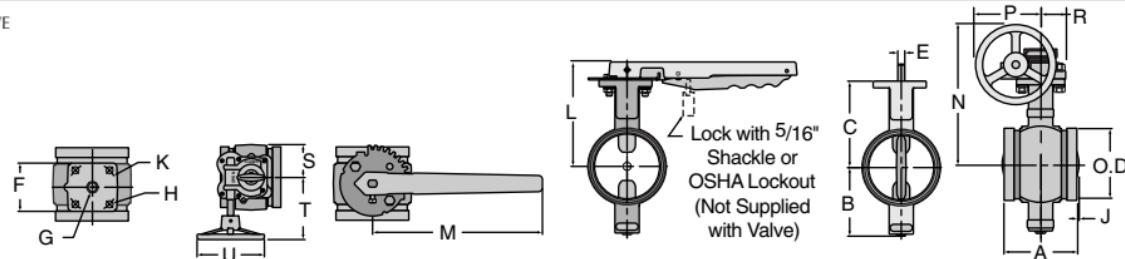
**FIGURE 7053-6D  $11\frac{1}{4}^\circ$  ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	5 1/4	3.2
50	60.3	133	1.5
2 1/2	2.875	5 1/2	5.3
65	73	140	2.4
3	3.500	5 3/4	7.3
80	88.9	146	3.3
3 1/2	4.000	6	9.2
90	101.6	152	4.2
4	4.500	6 1/2	11.4
100	114.3	165	5.2
5	5.563	8	19.4
125	141.3	203	8.8
6	6.625	9 1/2	30.1
150	168.3	241	13.7
8	8.625	12 3/4	60.5
200	219.1	324	27.4

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
10	10.750	16	107.2
250	273.1	406	48.6
12	12.750	19	157.5
300	323.9	483	71.4
14	14.000	22 1/4	202.3
350	355.6	565	91.8
16	16.000	25 1/2	265.2
400	406.4	648	120.3
18	18.000	28 3/4	336.5
450	457.2	730	152.6
20	20.000	31 3/4	416.3
500	508	806	188.8
24	24.000	38 1/4	601.4
600	609.6	972	272.8

**SERIES 7700**

BUTTERFLY VALVE

**SERIES 7700 - BUTTERFLY VALVE DIMENSIONS**

Dimensions	Valve Size (ANSI/DN)								
	2	2½	3	4	5	6	8	10	12
In./mm	50	65	80	100	125	150	200	250	300
O.D.	2 3/8	2 7/8	3 1/2	4 1/2	5 9/16	6 5/8	8 5/8	10 3/4	12 3/4
In./mm	60.3	73.0	88.9	114.3	141.3	168.3	219.1	273.1	323.9
A	3 3/16	3 13/16	3 3/16	4 5/8	5 13/16	5 13/16	5 1/4	6 1/4	6 1/2
	81.0	96.8	96.8	117.3	147.6	147.6	133.4	158.8	165.1
B	3	3 3/16	3 13/16	4 1/4	5	5 1/2	6 15/16	8	9
	75.4	80.8	96.5	108.5	126.5	138.9	175.8	202.9	229.4
C	4 3/16	4 3/8	5 1/16	5 5/8	5 7/8	6 3/8	7 3/4	9 1/2	10 1/2
	105.9	111.3	129.0	136.7	149.4	161.8	196.9	240.3	266.7
D	1 1/16	1 1/16	1 1/16	1 1/16	1 1/16	1 1/16	1 5/8	1 5/8	1 5/8
	26.9	26.9	26.9	26.9	26.9	26.9	41.1	41.1	41.1
E	7/16	7/16	7/16	7/16	7/16	7/16	3/4	3/4	3/4
	11.1	11.1	11.1	11.1	11.1	11.1	19.1	19.1	19.1
F	3	3	3	3	3	3	5	5	5
	76.2	76.2	76.2	76.2	76.2	76.2	127.0	127.0	127.0

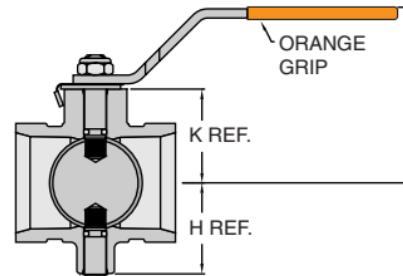
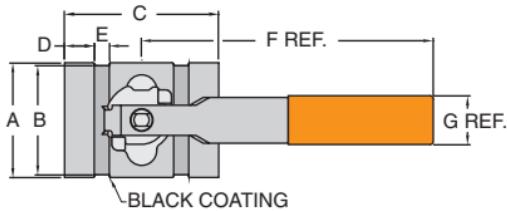
## Valves & Accessories

Series 7700 - Butterfly Valve Dimensions									
Dimensions	Valve Size (ANSI/DN)								
	2	2½	3	4	5	6	8	10	12
In./mm	50	65	80	100	125	150	200	250	300
G	9/16 14.3	9/16 14.3	9/16 14.3	9/16 14.3	7/8 22.2	7/8 22.2	1 25.4	1 1/4 31.8	1 1/4 31.8
H	7/16 11.1	7/16 11.1	7/16 11.1	7/16 11.1	7/16 11.1	7/16 11.1	1/2 13.5	1/2 13.5	1/2 13.5
J	-	-	-	-	-	1/8 3.3	1 3/8 34.8	1 7/8 47.0	2 3/4 70.1
K	3 76.2	3 76.2	3 76.2	3 76.2	3 76.2	3 76.2	5 127.0	5 127.0	5 127.0
L	5 5/16 135.1	5 1/2 140.5	6 1/4 158.2	6 1/2 165.9	7 178.6	7 1/2 191.0	9 7/16 240.3	-	-
M	10 1/2 266.7	10 1/2 266.7	10 1/2 266.7	10 1/2 266.7	10 1/2 266.7	10 1/2 266.7	15 381.0	-	-
N	7 13/16 198.0	8 203.3	8 1/16 221.1	9 228.7	9 1/2 241.4	10 253.9	14 15/16 379.2	16 5/8 422.7	20 11/16 525.3
P	4 102.1	4 102.1	4 102.1	4 102.1	4 102.1	4 102.1	8 1/16 204.5	8 1/16 204.5	11 5/8 295.4
R	1 1/2 38.2	1 1/2 38.2	1 1/2 38.2	1 1/2 38.2	1 1/2 38.2	1 1/2 38.2	2 5/16 58.5	2 5/16 58.5	2 9/16 65.5
S	2 51.0	2 51.0	2 51.0	2 51.0	2 51.0	2 51.0	2 5/8 66.0	2 5/8 66.0	3 1/4 83.0
T	6 5/16 160.3	6 5/16 160.3	6 5/16 160.3	6 5/16 160.3	6 5/16 160.3	6 5/16 160.3	10 13/16 275.3	10 13/16 275.3	13 13/16 350.3
U	5 127.0	5 127.0	5 127.0	5 127.0	5 127.0	5 127.0	12 304.8	12 304.8	18 457.2

3" or 5" handwheels may be included on valves sizes 2" - 4". Contact your Anvil Rep. for additional information.

**SERIES 7600**

BUTTERFLY VALVES

**SERIES 7600 - BUTTERFLY VALVE DIMENSIONS**

Nom. Size	Dimensions									
	A	B	C	D	E	F	G	H	K	L
In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm
2	2 $\frac{3}{8}$	2 $\frac{1}{4}$	3 $\frac{7}{16}$	$\frac{5}{8}$	$\frac{5}{16}$	6	1	11 $\frac{3}{16}$	2	3 $\frac{3}{16}$
50	60.3	57.2	87.4	15.9	8.7	152.4	25.4	46.0	50.8	81.0
2 $\frac{1}{2}$	2 $\frac{15}{16}$	2 $\frac{3}{4}$	3 $\frac{13}{16}$	$\frac{5}{8}$	$\frac{3}{8}$	6	1	2 $\frac{1}{16}$	2 $\frac{7}{16}$	3 $\frac{5}{8}$
65	74.2	70.2	96.8	15.9	8.9	152.4	25.4	52.3	62.0	91.9
3	3 $\frac{9}{16}$	3 $\frac{3}{8}$	3 $\frac{13}{16}$	$\frac{5}{8}$	$\frac{3}{8}$	8 $\frac{7}{16}$	1	2 $\frac{5}{8}$	2 $\frac{11}{16}$	4 $\frac{1}{4}$
80	90.3	86.4	96.8	15.9	8.9	214.4	25.4	66.5	68.1	108.0
4	4 $\frac{9}{16}$	4 $\frac{3}{8}$	4 $\frac{5}{8}$	$\frac{5}{8}$	$\frac{3}{8}$	8 $\frac{7}{16}$	1	3 $\frac{5}{16}$	3 $\frac{5}{16}$	4 $\frac{15}{16}$
100	116.1	111.8	117.3	15.9	8.9	214.4	25.4	84.1	84.1	125.5
6	6 $\frac{3}{4}$	6 $\frac{9}{16}$	5 $\frac{1}{4}$	$\frac{5}{8}$	$\frac{3}{8}$	12 $\frac{1}{4}$	1 $\frac{1}{4}$	4 $\frac{3}{8}$	4 $\frac{3}{8}$	7
150	171.0	166.6	133.4	15.9	8.9	311.2	31.8	111.3	111.3	177.8

## Valves &amp; Accessories

## SERIES 8000GR

## BUTTERFLY VALVE

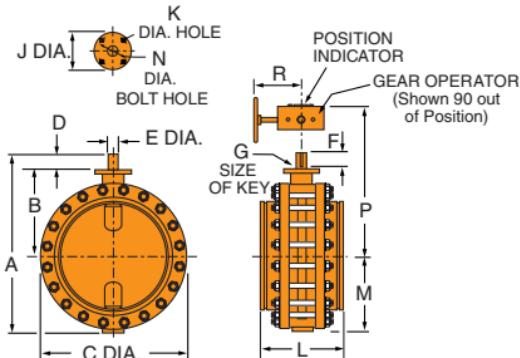
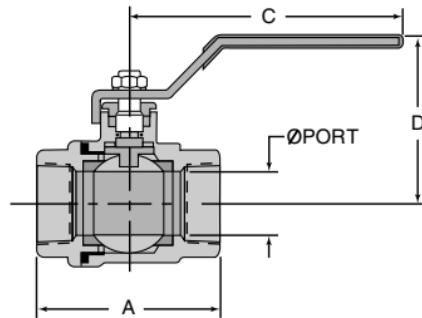


FIGURE 8000GR - BUTTERFLY VALVE DIMENSIONS

Nominal Size	O.D.	A	B	C	D	E	F	G	J	K	L	M	N	P	R
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm
14 350	14.000 356	26.25 667	13.25 337	21.00 533	2.25 57	1.50 38	2.00 51	¾ x ¾ 87	6.00 152	0.53 13	13.06 332	10.75 273	5.00 127	17.94 456	10.00 254
16 400	16.000 406	29.50 749	14.75 375	23.50 597	2.25 57	1.50 38	2.00 51	¾ x ¾ 87	6.00 152	0.53 13	14.33 364	12.5 318	5.00 127	19.44 494	10.00 254
18 450	18.000 457	32.75 832	15.75 400	25.00 635	3.00 76	1.75 44	2.38 60	¾ x ¾ 87	6.75 171	0.53 13	15.40 391	14.00 356	5.00 127	20.44 519	10.00 254
20 500	20.000 508	34.00 864	16.25 413	27.50 699	3.00 76	1.75 44	2.60 66	¾ x ¾ 87	6.75 171	0.53 13	16.38 416	15.00 381	5.00 127	20.94 532	10.00 254
24 600	24.000 610	39.37 1.000	19.12 486	32.00 813	3.00 76	2.25 57	3.25 83	½ x ½ 116	9.50 241	0.81 21	18.26 464	16.75 425	6.50 165	24.38 619	10.25 260

**FIG. 141S, FIG. 171N & FIG. 171S**

INTERNATIONAL BRASS BALL VALVES

**NOTES**

1. Dimensions of solder joint ends conform to ANSI B16.22. Solder end valves are designed to be used with solders not exceeding a melting point of 470°F/250°C. Higher temperatures may damage the seal material.

2. For solder joint valves, the pressure/temperature rating is dependent on the solder material used. Please refer to the limitations listed in ANSI B16.18.

3. Rate of Flow Calculations for liquids:

To determine the flow rate of a liquid passing through a valve, use the following formula:

$$Q_L = C_v \left( \sqrt{\frac{\Delta P}{S_L}} \right)$$

Where:  $Q_L$  = flow of liquid in gallons per minute (GPM)

$C_v$  = flow coefficient

$\Delta P$  = pressure drop (PSI)

$S_L$  = specific gravity of liquid

**DIMENSIONS**

Valve Code	Size In./mm	Port Dia. In./mm	A In./mm	C In./mm	D In./mm	Cv	Approx. Wt. Ea. Lbs./Kg
141S Standard Port	1/2 15	1/2 12	2 1/16 52	3 1/8 98	1 13/16 46	6.3	0.7 0.3
	3/4 20	9/16 14	2 11/16 68	3 1/8 98	1 15/16 49	9.5	0.8 0.4
	1 25	3/4 19	3 3/16 81	4 13/16 122	2 9/16 59	22.2	1.1 0.5
	1 1/4 32	1 25	3 3/16 90	4 13/16 122	2 1/2 63	30.8	1.5 0.7
	1 1/2 40	1 1/4 32	4 102	6 152	3 1/16 78	60.9	2.2 1.0
	2 50	1 9/16 40	5 1/16 128	6 152	3 9/16 84	92.9	3.1 1.4

## Valves & Accessories

**FIG. 141S, FIG. 171N & FIG. 171S**

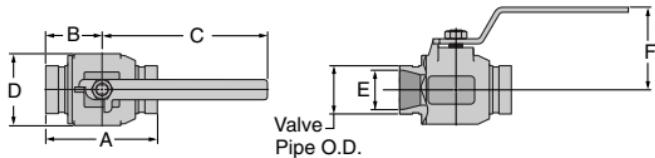
INTERNATIONAL BRASS BALL VALVES

DIMENSIONS								
Valve Code	Size	Port Dia.	A	C	D	Cv	Approx. Wt. Ea.	
	In./mm	In./mm	In./mm	In./mm	In./mm		Lbs./Kg	
171N Full Port	1/4	3/8	2	3 1/8	1 3/4	6	0.3	
	8	10	51	98	45		0.1	
	3/8	3/8	2	3 1/8	1 3/4	7	0.3	
	10	10	51	98	45		0.1	
	1/2	9/16	2 7/16	3 1/8	1 1/8	19	0.4	
	15	14	62	98	48		0.2	
	3/4	3/4	2 11/16	4 13/16	2 1/4	35	0.7	
	20	19	68	122	57		0.3	
	1	1 5/16	3 1/16	4 13/16	2 7/16	50	1.0	
	25	24	78	122	62		0.5	
	1 1/4	1 1/4	3 7/16	6	3 1/16	104	2.0	
	32	32	87	152	78		0.9	
	1 1/2	1 1/16	3 7/8	6	3 5/16	268	3.1	
	40	40	98	152	84		1.4	
	2	1 15/16	4 5/16	6 3/8	3 13/16	309	4.2	
	50	49	110	162	97		1.9	
	2 1/2	2 9/16	5 9/16	8 1/16	5	629	8.0	
	65	65	141	205	127		3.7	
Threaded End	3	3 1/8	6 7/16	8 5/16	5 7/16	1018	12.0	
	75	79	164	205	138		5.9	
	4	3 15/16	7 5/8	10 1/4	6 5/16	1622	22.0	
	100	100	194	260	160		10.0	

DIMENSIONS								
Valve Code	Size	Port Dia.	A	C	D	Cv	Approx. Wt. Ea.	
	In./mm	In./mm	In./mm	In./mm	In./mm		Lbs./Kg	
171S Full Port	1/2	9/16	2 1/2	3 7/8	1 1/8	19	0.5	
	15	14	64	98	48		0.2	
	3/4	3/4	3	4 13/16	2 5/16	35	0.7	
	20	19	76	122	59		0.3	
	1	1	3 9/16	4 13/16	2 1/2	50	1.1	
	25	25	91	122	64		0.5	
	1 1/4	1 1/4	4 9/16	6	3 1/8	104	2.0	
	32	32	103	152	79		0.9	
	1 1/2	1 9/16	4 9/16	6	3 3/8	268	2.7	
	40	40	116	152	86		1.2	
	2	1 15/16	5 7/16	6 7/16	3 11/16	309	3.9	
	50	49	138	164	94		1.8	
	2 1/2	2 9/16	6 7/8	8 7/16	5	629	9.4	
	65	65	175	205	127		4.3	
	3	3 1/8	8 9/16	8 1/16	5 7/16	1018	14.5	
	75	79	208	205	138		6.6	
	4	3 15/16	10 5/16	10 1/4	6 5/16	1622	24.7	
	100	100	262	260	160		11.2	
Soldered End								

**FIG. 7500**

BALL VALVES

**SERIES 7500 - BALL VALVE**

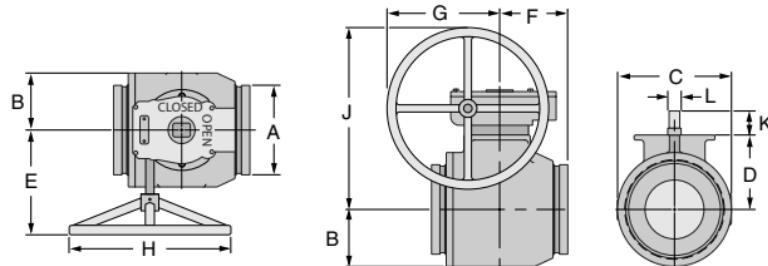
Size ANSI	O.D.	Dimensions							Approx. Wt. Ea.
		A	B	C	D	E	F	Cv	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
2	2.375	5½	2¾	8¼	3⅓/16	11½/16	4½	165	8
50	60.3	140	70	209	81	49	105		3.6
3	3.500	6¾	3¾	10	41¾/16	2⅜	41¾/16	310	18
80	88.9	171	85	254	122	74	121		8.2
4	4.500	8¼	4½	16	6½/16	31¾/16	6	815	38
100	114.3	210	105	406	176	97	152		17.2
6 *	6.625	10½	5½/16	28	8¾/16	51½/16	7½	1500	106
150	168.3	257	128	711	215	144	194		48.1

\* Bare Stem

## Valves &amp; Accessories

## SERIES 7500

## BALL VALVES

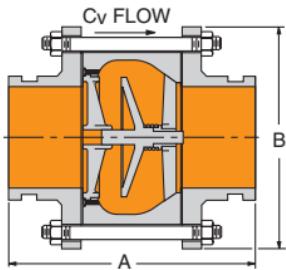


SERIES 7500 - BALL VALVE WITH GEAR ACTUATOR

Size ANSI	O.D.	Dimensions												Approx. Wt. Ea.
		A	B	C	D	E	F	G	H	J	K	L		
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg	
6	6.625	6½	4¼	8⅞	5½	10¼	5⅓	8⅓	12	13½	11¾	1	9.6	
150	168.3	168.7	107.4	214.6	140.5	260.4	128.0	206.4	304.8	342.9	45.2	25.4	4.4	

**FIG. 400G**

GROOVED-END SILENT CHECK VALVE

**FIGURE 400G - GROOVED-END SILENT CHECK VALVE**

Nom. Size	O.D.	Model	A	B	C <sub>v</sub> Flow	Approx. Wt. Each
In./mm	In./mm	Number	In./mm	In./mm		Lbs./Kg
2	2.375	402G	6	6	66	12
50	60.3		152	152	1,676	5.4
2½	2.875	4025G	6½	7	88	15
65	73.0		159	178	2,235	6.8
3	3.500	403G	6¾	7½	130	20
80	88.9		164	191	3,302	9.1
4	4.500	404G	8⅛	9	228	36
100	114.3		206	229	5,791	16.3
5	5.563	405G	11¼	10	350	50
125	141.3		286	254	8,890	22.7
6	6.625	406G	12½	11	520	68
150	168.3		311	279	13,208	30.8
8	8.625	408G	13¾	13½	900	140
200	219.1		349	343	22,860	63.5
10	10.750	410G	16	16	1,450	198
250	273.1		406	406	36,830	89.8

## Valves &amp; Accessories

## SERIES 7800

## CHECK VALVES

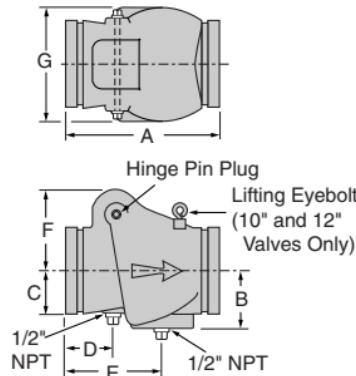


FIGURE 7800 - CHECK VALVE

Nom. Size	O.D.	Nominal Dimensions							Approx. Wt. Ea. <i>Lbs./Kg.</i>
		A	B	C	D	E	F	G	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm
2	2.375	6 <sup>3</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>8</sub>	1 <sup>7</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>16</sub>	4 <sup>3</sup> / <sub>8</sub>	7.5
50	60.3	171	60	36	44	114	81	111	3.4
2½	2.875	7 <sup>1</sup> / <sub>4</sub>	2 <sup>7</sup> / <sub>16</sub>	1 <sup>9</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	3 <sup>13</sup> / <sub>16</sub>	3 <sup>5</sup> / <sub>8</sub>	4 <sup>1</sup> / <sub>2</sub>	10.5
65	73.0	184	61	39	44	96	92	114	4.8
3	3.500	7 <sup>3</sup> / <sub>4</sub>	2 <sup>5</sup> / <sub>8</sub>	2	1 <sup>13</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>16</sub>	3 <sup>11</sup> / <sub>16</sub>	4 <sup>15</sup> / <sub>16</sub>	11.5
80	88.9	197	67	51	46	103	93	125	5.2
4	4.500	8 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>4</sub>	6	13.5
100	114.3	206	79	57	64	128	108	152	6.1
5	5.563	9 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>2</sub>	2 <sup>3</sup> / <sub>4</sub>	2 <sup>7</sup> / <sub>16</sub>	5 <sup>13</sup> / <sub>16</sub>	4 <sup>5</sup> / <sub>8</sub>	6 <sup>3</sup> / <sub>4</sub>	19.0
125	141.3	248	89	70	61	147	117	171	8.6
6	6.625	12 <sup>3</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>4</sub>	3 <sup>5</sup> / <sub>16</sub>	3 <sup>1</sup> / <sub>8</sub>	6 <sup>1</sup> / <sub>4</sub>	6 <sup>3</sup> / <sub>4</sub>	8 <sup>1</sup> / <sub>2</sub>	33.5
150	168.3	324	108	84	79	159	171	216	15.2
8	8.625	14 <sup>9</sup> / <sub>16</sub>	5 <sup>1</sup> / <sub>16</sub>	3 <sup>15</sup> / <sub>16</sub>	4	5 <sup>15</sup> / <sub>16</sub>	8	10 <sup>1</sup> / <sub>4</sub>	59.0
200	219.1	365	128	100	102	150	203	260	26.8
10	10.750	18	6 <sup>5</sup> / <sub>16</sub>	4 <sup>15</sup> / <sub>16</sub>	4 <sup>9</sup> / <sub>16</sub>	6 <sup>7</sup> / <sub>8</sub>	9 <sup>9</sup> / <sub>16</sub>	12 <sup>11</sup> / <sub>16</sub>	130.0
250	273.1	457	160	125	115	175	233	322	59.0
12	12.750	21	7 <sup>5</sup> / <sub>16</sub>	6	5 <sup>1</sup> / <sub>16</sub>	7 <sup>1</sup> / <sub>4</sub>	10 <sup>3</sup> / <sub>8</sub>	14 <sup>3</sup> / <sub>4</sub>	183.0
300	323.9	533	185	152	128	184	264	375	83.0

**GBV-G**

BALANCING VALVES

2½" to 12" Ductile Iron, Grooved-End Straight

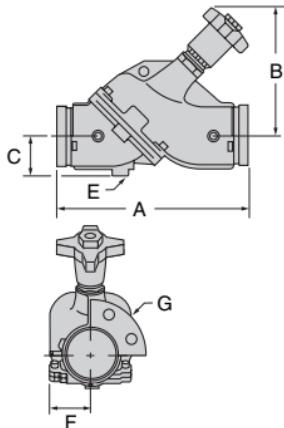


FIGURE GBV-G - GROOVED-END STRAIGHT BALANCING VALVES

Nom. Size	O.D.	A	B Open	C	E	F	Flange Diameter		Approx. Wt. Each
							G Flange 125#	G Flange 250#	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
2½ 65	2.875 73.0	12 305	9½ 244	2¾ 70	1 25	29½ 65	7 178	7½ 191	25 11.3
3 80	3.500 88.9	12 305	10½ 267	2¼ 61	1 25	3 76	7½ 191	8½ 210	28 12.7
4 100	4.500 114.3	14 356	10½ 268	76	3 32	3½ 87	9¼ 235	10 254	41 18.6
5 125	5.563 141.3	17½ 445	13½ 331	3½ 92	1¼ 32	4½ 125	10 254	11 279	90 40.8
6 150	6.625 168.3	20½ 525	13¾ 349	4½ 112	2 51	5½ 149	11 279	12½ 318	130 59.0
8 200	8.625 219.1	28½ 716	24½ 625	5½ 144	2¼ 57	7½ 200	13½ 343	15 381	310 140.6
10 250	10.750 273.1	30 762	26½ 673	6½ 166	2¼ 57	9½ 240	16 406	17½ 445	460 208.7
12 300	12.750 323.9	38½ 966	28½ 722	7½ 194	2¼ 57	12½ 321	19 483	20½ 521	870 394.6

**NOTE:** Grooved-Ends are for connection of components with dimensions conforming to Gruvlok® standard grooved specifications for IPS pipe.

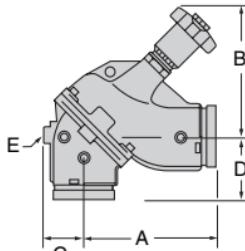
# Valves & Accessories

## GBV-A

BALANCING VALVE

2½" to 12" Ductile Iron, Grooved-End Angle

GRUVLOK®

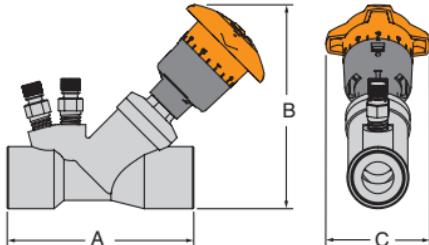


Nom. Size	O.D.	A	B Open	C	D	E	F	Flange Diameter		Approx. Wt. Each
								G Flange 125#	G Flange 250#	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
2½ 65	2.875 73.0	7⅜ 187	9⅝ 244	2⅓ 70	4⅔ 117	1 25	2⅖ 65	7 178	7½ 191	25 11.3
3 80	3.500 88.9	8⅜ 213	10⅓ 267	2⅕ 61	3⅔ 98	1 25	3 76	7½ 191	8⅔ 210	28 12.7
4 100	4.500 114.3	9⅝ 244	10Ⅿ₁₆ 268	3 76	4⅔ 111	1¼ 32	3⅗₁₆ 87	9¼ 235	10 254	41 18.6
5 125	5.563 141.3	12 305	13⅓₁₆ 331	3⅔ 92	5⅓ 140	1¼ 32	4⅕₁₆ 125	10 254	11 279	90 40.8
6 150	6.625 168.3	14⅓ 359	13⅔ 349	6⅔ 112	6⅔ 168	2 51	5⅔ 149	11 279	12½ 318	130 59.0
8 200	8.625 219.1	18⅕₁₆ 481	24⅔ 625	5⅓₁₆ 144	9⅓₁₆ 233	2¼ 57	7⅔ 200	13½ 343	15 381	310 140.6
10 250	10.750 273.1	20Ⅴ₁₆ 515	26⅓ 673	6⅔ 166	9⅔ 248	2¼ 57	9⅕₃₂ 240	16 406	17½ 445	460 208.7
12 300	12.750 323.9	24⅓₁₆ 611	28⅓₁₆ 722	7⅔ 194	12⅔ 356	2¼ 57	12⅔ 321	19 483	20½ 521	870 394.6

**NOTE:** Grooved-Ends are for connection of components with dimensions conforming to Gruvlok® standard grooved specifications for IPS pipe.

**GBV-S (SOLDER)**

FIVE TURN CIRCUIT BALANCING VALVES

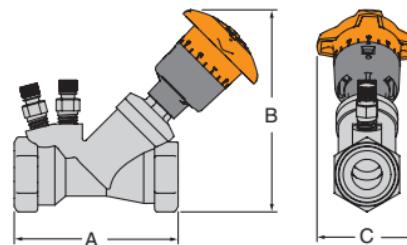
**MODEL: GBV-S - 1/2" - 2"**

Model	Nominal Size	A	B	C	Approx. Wt. Ea.
	In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
GBV050VS	1/2" 15	3 9/16 81	4 9/16 116	2 3/4 70	1.1 0.5
GBV075VS	3/4" 20	3 9/16 93	4 9/16 118	2 3/4 70	1.1 0.5
GBV100VS	1" 25	4 1/4 108	4 15/16 126	2 3/4 70	1.7 0.8
GBV125VS	1 1/4" 32	4 15/16 125	5 5/8 137	2 3/4 70	2.3 1.0
GBV150VS	1 1/2" 40	5 11/16 144	5 5/8 142	2 3/4 70	3.2 1.5
GBV200VS	2" 50	7 179	6 3/8 162	2 3/4 70	5.4 2.5

See Installation &amp; Assembly directions on pages 186-191.

**GBV-T (NPT-THREADED)**

FIVE TURN CIRCUIT BALANCING VALVES

**MODEL: GBV-T - 1/2" - 2"**

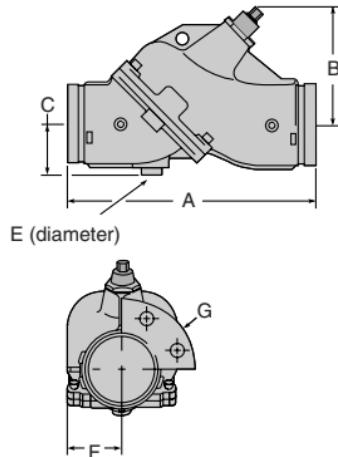
Model	Nominal Size	A	B	C	Approx. Wt. Ea.
	In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
GBV050VT	1/2" 15	3 76	4 5/8 117	2 3/4 70	1.1 0.5
GBV075VT	3/4" 20	3 1/4 83	4 7/8 125	2 3/4 70	1.2 0.6
GBV100VT	1" 25	3 13/16 97	5 1/4 135	2 3/4 70	1.9 0.8
GBV125VT	1 1/4" 32	4 5/16 110	5 5/8 143	2 3/4 70	2.3 1.1
GBV150VT	1 1/2" 40	5 1/16 129	5 7/8 150	2 3/4 70	3.5 1.6
GBV200VT	2" 50	6 153	6 11/16 170	2 3/4 70	6.0 2.5

See Installation &amp; Assembly directions on pages 186-191.

## Valves & Accessories

### FTV-S (STRAIGHT)

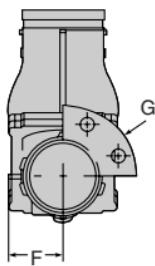
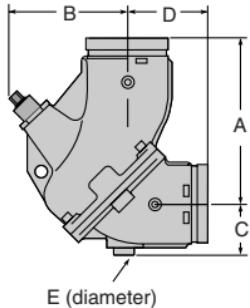
TRI-SERVICE VALVE



MODEL FTV-S - (STRAIGHT)									
Connection Size	A	B (fully open)	C	E	F	Flange 125/150 PSI G	Flange 250/300 PSI G	Approx. Wt. Each	
In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	lbs/kg	
2½ 65	12 305	7 178	2¾ 70	1 25	2⅞ 65	7 178	7½ 191	19 9	
3 880	12 305	7¹³/₁₆ 198	2⁷/₁₆ 62	1 25	3 76	7½ 191	8¹/₄ 210	24 11	
4 100	14 356	8 203	3 76	1¹/₄ 32	3¹/₄ 87	9¹/₄ 235	10 254	42 19	
5 125	17½ 445	10¹/₈ 257	3⁵/₈ 92	1¹/₄ 32	4¹⁵/₁₆ 125	10 254	11 279	81 37	
6 150	20¹¹/₁₆ 525	10³/₈ 264	4⁷/₁₆ 113	2 51	5⁷/₈ 149	11 279	12½ 318	120 54	
8 200	28³/₁₆ 716	22¹³/₁₆ 579	5¹¹/₁₆ 144	2¹/₄ 57	7¹/₈ 200	13¹/₂ 343	15 381	300 136	
10 250	30 762	28⁵/₈ 727	6⁹/₁₆ 167	2¹/₄ 57	9¹⁵/₃₂ 241	16 409	17½ 445	450 204	
12 300	38¹/₁₆ 967	32⁵/₈ 829	7⁵/₈ 194	2¹/₄ 57	12⁵/₈ 321	19 483	20½ 521	850 390	

**FTV-A (ANGLE BODY)**

TRI-SERVICE VALVE



MODEL FTV-A - (ANGLE)

Connection Size	A	B (fully open)	C	D	E	F	Flange 125/150 PSI G	Flange 250/300 PSI G	Approx. Wt. Each
In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	lbs/kg
2½ 65	7¾ 187	7 178	2¾ 70	4½ 117	1 25	2⁹/₁₆ 65	7 178	7½ 191	19 9
3 880	8¾ 208	7¹³/₁₆ 198	2⁷/₁₆ 62	3¾ 98	1 25	3 76	7½ 191	8½ 210	24 11
4 100	9⁹/₈ 244	8 203	3 76	4¾ 111	1¼ 32	3⁷/₁₆ 87	9¼ 235	10 254	42 19
5 125	12 305	10¹/₈ 257	3⁵/₈ 92	5½ 140	1¼ 32	4¹⁵/₁₆ 125	10 254	11 279	81 37
6 150	14¹/₈ 359	10³/₈ 264	4⁷/₁₆ 113	6⁵/₈ 168	2 51	5⁷/₈ 149	11 279	12½ 318	120 54
8 200	18¹⁵/₁₆ 481	18³/₄ 476	5¹¹/₁₆ 144	9³/₁₆ 233	2¹/₄ 57	7¾ 200	13½ 343	15 381	300 136
10 250	20⁵/₁₆ 516	24 610	6⁹/₁₆ 167	9¾ 248	2¹/₄ 57	9¹⁵/₃₂ 241	16 409	17½ 445	450 204
12 300	24¹/₁₆ 611	26¹/₄ 667	7⁵/₈ 194	14 356	2¹/₄ 57	12⁵/₈ 321	19 483	20½ 521	860 390

## Valves & Accessories

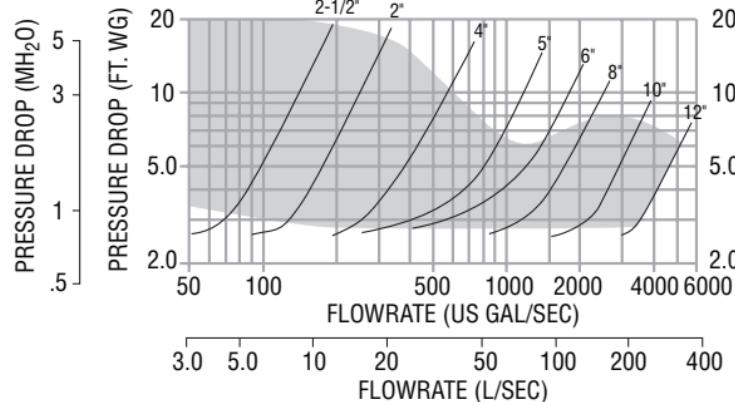
### FTV-S (STRAIGHT) AND FTV-A (ANGLE BODY)

#### TRI-SERVICE VALVE PERFORMANCE CURVE

##### Performance Curve Valve in Full Open Position

- 1. Minimum Flow Rate** – To ensure sufficient flow to hold disc in full open position during operation, size valves in shaded area only of Performance Curve.
- 2. Maximum Flow Rate** – Select valve in shaded area only. However, consideration should be given to selecting the valve with the lowest pressure drop and velocity in accordance with ASHRAE practice. This will ensure a quiet, energy-efficient system and maximum valve life.

Tri-Service Performance Curve  
with Valve in Full Open Position



## FTV-S (STRAIGHT) AND FTV-A (ANGLE BODY)

### TRI-SERVICE VALVE PERFORMANCE CURVE

1. Record the size of valve and stem position using the Flow Indicator Scale. Calculate percentage of valve opening referring to table below:

Valve Size	2½	3	4	5	6	8	10	12
Number of Rings (Valve Full Open)	5	5	6	9	10	12	18	28

2. Measure and record the differential pressure across the valve in the throttled position.
3. Locate percentage of valve opening on the bottom of Flow Characteristic Curve. Project line vertically up to intersect with the Valve Characteristic Curve and from this point project line horizontally across to the left of the chart and record the percentage of maximum flow rate.
4. On the Tri-Service Performance Curve locate the differential pressure obtained in Step 2 and project line horizontally across to intercept with Valve Performance Curve. Drop a line vertically down to read the flow rate at the bottom of the chart.
5. To calculate flow rate of valve in the throttled position, multiply the flow rate from Step 4 by the percentage flow rate from Step 4 by the percentage flow rate from Step 2 divided by 100.

**Example:**

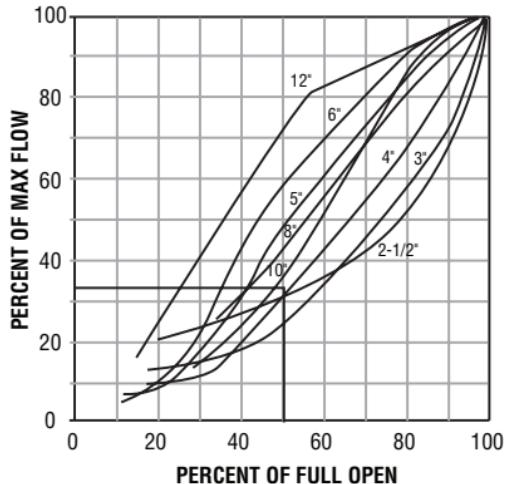
Valve size 4 in., Differential Pressure in 5.4 ft. (1.65m)•

Number of rings open 3, (3 rings / 6 rings x 100) = 50% throttled

**Solution:**

- From the Tri-service performance Curve, a 4 in. valve with 5.4 ft. pressure drop (1.65m.) represents a flow of 400 USgpm (25.2 l/s).
- From Flow Characteristic, a 4 in. valve, 50% open, represents 34% of maximum flow.
- Approximate flow of a 4 in. valve, with a 5.4 ft. (1.65m) pressure drop when 50% throttled is:  $(400 \times 34)/100 = 136$  USgpm,  $(25.2 \times 34)/100 = 8.57$  L/sec.

Inherent Flow Characteristic Curve  
with Valve in Throttled Position

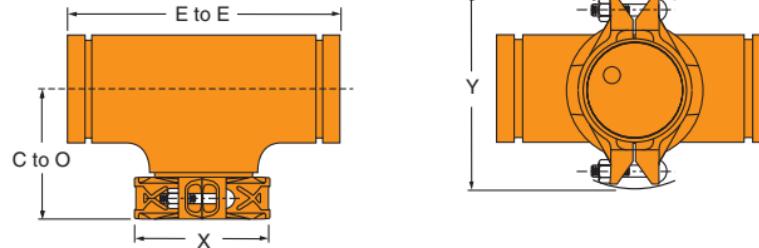


**Note:** To prevent premature valve failure, it is not recommended that the valve operate in the throttled position with more than 25 ft. pressure differential. Instead the pump impeller should be trimmed or valves located elsewhere in the system to partially throttle the flow.

## Valves &amp; Accessories

**FIG. 7260**

GRUVLOK TEE STRAINER



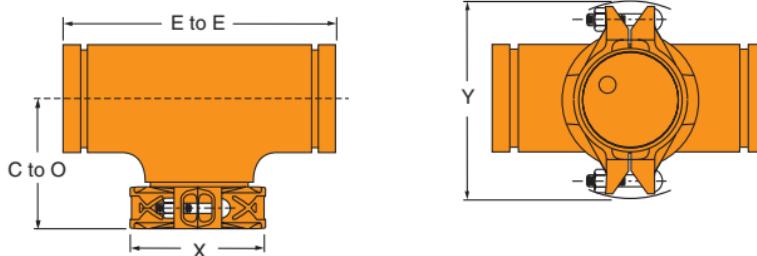
**NOTE:** This illustration shows the required orientation of the Rigidlok access coupling for assembly with a grooved-end flange.

FIGURE 7260 - TEE STRAINER (CONTINUES ON NEXT PAGE)

Nom. Size	O.D.	Max.* Working Pressure	E to E	C to O	X	Y	Basket Removal	Approx. Wt. Ea.
In./DN(mm)	In./mm	PSI/bar	In./mm	In./mm	In./mm	In./mm	Clearance	Lbs./Kg
2	2.375	750	6½	4¼	3½	5¾	4¾	6.0
50	60.3	51.7	165	108	89	149	111	2.7
2½	2.875	750	7½	4¾	4	6½	5½	8.0
65	73.0	51.7	191	121	102	165	130	3.6
3	3.500	750	8½	5¼	4¾	7	6	13.0
80	88.9	51.7	216	133	121	178	152	5.9
4	4.500	750	10	6⅓	5¾	8¾	7¼	19.0
100	114.3	51.7	254	156	149	213	184	8.6
5	5.563	750	11	6¾	7	10½	8¼	30.0
125	141.3	51.7	279	168	178	257	210	13.6
6	6.625	750	13	7¾	8½	11½	9¾	45.0
150	168.3	51.7	330	194	206	283	248	20.4
8	8.625	600	15½	9½	10½	14½	12	79.0
200	219.1	41.4	394	232	267	359	305	35.8

**FIG. 7260 (CONT'D.)**

GRUVLOK TEE STRAINER



**NOTE:** This illustration shows the required orientation of the Rigidlok access coupling for assembly with a grooved-end flange.

**FIGURE 7260 - TEE STRAINER (CONTINUES FROM PREVIOUS PAGE)**

Nom. Size	O.D.	Max.* Working Pressure	E to E	C to O	X	Y	Basket Removal	Approx. Wt. Ea.
In./DN(mm)	In./mm	PSI/bar	In./mm	In./mm	In./mm	In./mm	Clearance	Lbs./Kg
10	10.750	500	18	10 $\frac{1}{8}$	12 $\frac{1}{8}$	17 $\frac{1}{8}$	14 $\frac{1}{4}$	133
250	273.1	34.5	457	264	327	435	362	60.3
12	12.750	400	20	11 $\frac{1}{8}$	15	19 $\frac{1}{8}$	16 $\frac{1}{4}$	187
300	323.9	27.6	508	289	381	486	413	84.8
14	14.000	300	22	12 $\frac{3}{4}$	16 $\frac{1}{8}$	20 $\frac{1}{2}$	17 $\frac{1}{4}$	272
350	355.6	20.7	559	324	410	521	438	123.4
16	16.000	300	24	12	18 $\frac{1}{8}$	22 $\frac{1}{4}$	20	350
400	406.4	20.7	610	305	460	565	508	158.8
18	18.000	300	31	15 $\frac{1}{2}$	20 $\frac{1}{2}$	24 $\frac{1}{8}$	24 $\frac{1}{2}$	400
450	457.2	20.7	787	394	521	619	622	181.4

\*Maximum working pressure is based upon the performance capability of the Gruvlok Strainer. Maximum system working pressure is dependent upon the couplings used for installation and the pressure capability of other system components.

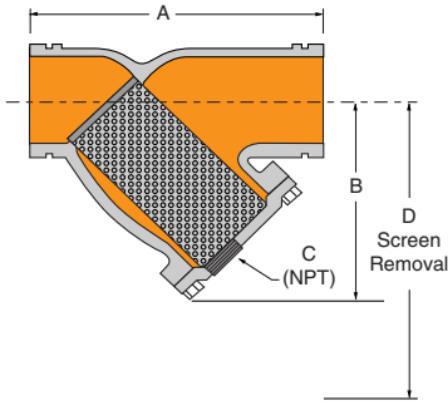
14" - 18" Fabricated

Not for use with copper systems.

## Valves &amp; Accessories

## MODEL 758G

GROOVED-END "WYE" STRAINER



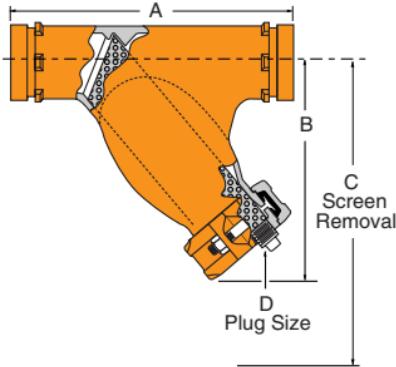
Nominal Size In./DN(mm)	O.D. In./mm	Dimensions				Approx. Wt. Each Lbs./Kg
		A In./mm	B In./mm	C Plug Size In./mm	D In./mm	
2	2.375	7 $\frac{1}{8}$	5 $\frac{1}{4}$	1 $\frac{1}{2}$	7	12.0
50	60.3	200	133	25	178	5.4
2 $\frac{1}{2}$	2.875	10	6 $\frac{1}{2}$	1	9 $\frac{3}{4}$	18.0
65	73.0	254	165	25	248	8.2
3	3.500	10 $\frac{1}{8}$	7	1	10	23.0
80	88.9	257	178	25	254	10.4
4	4.500	12 $\frac{1}{8}$	8 $\frac{1}{4}$	1 $\frac{1}{2}$	12	42.0
100	114.3	308	210	38	305	19.1
5	5.563	15 $\frac{1}{8}$	11 $\frac{1}{4}$	2	17	80.0
125	141.3	396	286	51	432	36.3
6	6.625	18 $\frac{1}{8}$	13 $\frac{1}{2}$	2	20	112.0
150	168.3	470	343	51	508	50.8
8	8.625	21 $\frac{1}{8}$	15 $\frac{1}{2}$	2	22 $\frac{3}{4}$	205.0
200	219.1	549	394	51	577	93.0
10	10.750	25 $\frac{1}{4}$	18 $\frac{1}{2}$	2	28	277.0
250	273.1	654	470	51	711	125.6
12	12.750	30	21 $\frac{1}{4}$	2	30	470.0
300	323.9	762	552	51	762	213.2

\*Maximum working pressure is based upon the performance capability of the Gruvlok® Strainer. Maximum system working pressure is dependant upon the couplings used for installation and the pressure capacity of other system components.

Not for use with copper systems.

**MODEL 768G**

GROOVED-END "WYE" STRAINER



Not for use in copper systems.

- Pressure ratings listed are CWP (cold water pressure) or maximum working pressure within the service temperature range of the gasket used in the coupling. This rating may occasionally differ from maximum working pressures listed and/or approved by UL, ULC, and/or FM as testing conditions and test pipes differ.
- Maximum working pressure and end loads listed are total of internal and external pressures and loads based on Sch. 40 steel pipe with roll grooves to ANSI C606-97 specifications.
- For one time field test only the maximum joint working pressure may be increased 1½ times the figures shown.
- Warning: Piping systems must always be depressurized and drained before attempting disassembly and or removal of any components.

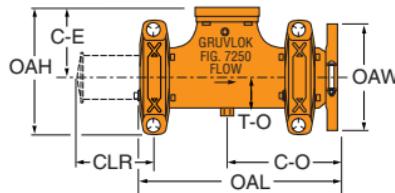
FIGURE 768 G - GROOVED-END "WYE" STRAINER

Nominal Size	O.D.	Working Pressure	Dimensions				Cv Values	Approx. Wt. Each
			A	B	C	D Plug Size		
In./DN(mm)	In./mm	PSI/bar	In./mm	In./mm	In./mm	In./mm		Lbs./Kg
2	2.375	300	9 <sup>3</sup> / <sub>4</sub>	7 <sup>1</sup> / <sub>8</sub>	4 <sup>9</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	59	9.3
50	60.3	20.7	248	192	116	12		4.2
2 <sup>1</sup> / <sub>2</sub>	2.875	300	10 <sup>3</sup> / <sub>4</sub>	7 <sup>13</sup> / <sub>16</sub>	4 <sup>13</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	92	13.2
65	73.0	20.7	273	211	122	12		6.0
3	3.500	300	11 <sup>3</sup> / <sub>4</sub>	8 <sup>11</sup> / <sub>16</sub>	5 <sup>1</sup> / <sub>16</sub>	1	162	18.0
80	88.9	20.7	298	231	129	25		8.2
4	4.500	300	14 <sup>1</sup> / <sub>4</sub>	10 <sup>5</sup> / <sub>8</sub>	6 <sup>5</sup> / <sub>8</sub>	1	284	26.4
100	114.3	20.7	362	281	168	25		12.0
5	5.563	300	16 <sup>1</sup> / <sub>2</sub>	13	10 <sup>3</sup> / <sub>16</sub>	1	410	46.4
125	141.3	20.7	419	330	258	25		22.0
6	6.625	300	18 <sup>1</sup> / <sub>2</sub>	14 <sup>1</sup> / <sub>16</sub>	8 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	770	70.4
150	168.3	20.7	470	357	219	38		32.0
8	8.625	300	24	17 <sup>7</sup> / <sub>8</sub>	11 <sup>3</sup> / <sub>16</sub>	1 <sup>1</sup> / <sub>2</sub>	1010	121.0
200	219.1	20.7	610	454	284	38		55.0
10	10.750	300	27	20 <sup>9</sup> / <sub>16</sub>	12 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	1800	182.6
250	273.1	20.7	686	522	320	38		83.0
12	12.750	300	30	24	14 <sup>3</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	2800	277.2
300	323.9	20.7	762	609	366	38		126.0
14	14.000	300	40	29 <sup>15</sup> / <sub>16</sub>	18 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	4600	418.0
350	355.6	20.7	1016	760	480	38		190.0
16	16.000	300	42	30 <sup>9</sup> / <sub>16</sub>	19	1 <sup>1</sup> / <sub>2</sub>	5800	495.0
400	406.4	20.7	1067	777	483	38		225.0

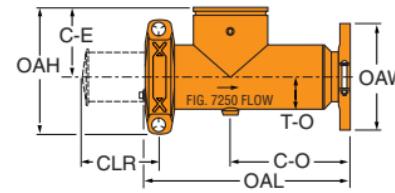
## Valves &amp; Accessories

FIG. 7250

SUCTION DIFFUSER



2½" x 2½" thru 10" x 8"



10" x 10" thru 16" x 14"

FIGURE 7250 - SUCTION DIFFUSER

Nominal Size	O.D.	System Side (Grooved)	Pump Side (Flanged)	C-E	C-O	OAL	OAH	OAW	CLR	T-O	Orifice Cylinder Open Area	Max. Working Pressure	Approx. Wt. Each
In./DN(mm)	In./mm	In./DN(mm)	In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In. Sq./cm. Sq.	PSI/bar	Lbs./Kg
2½ x 2½ 65 x 65	2.875 x 2.875 73.0 x 73.0	2½ 65	2½ 65	5 127	8¼ 210	13½ 343	9 229	9½ 241	12½ 318	2¾ 56	47.0 303	300 20.7	36 16.3
3 x 2 80 x 65	3.500 x 2.375 88.9 x 60.3	3 80	2 50	5 127	8 203	14 356	9 229	8⅔ 213	13½ 343	2¾ 56	47.0 303	300 20.7	36 16.3
3 x 2½ 80 x 65	3.500 x 2.875 88.9 x 73.0	3 80	2½ 65	5 127	8¼ 210	13½ 343	9 229	9½ 241	12½ 318	2¾ 56	47.0 303	300 20.7	36 16.3
3 x 3 80 x 80	3.500 x 3.500 88.9 x 88.9	3 80	3 80	5 127	8¼ 210	13½ 343	9 229	9½ 241	12½ 318	2¾ 56	51.0 329	300 20.7	37 16.8
4 x 2½ 100 x 65	4.500 x 2.875 114.3 x 2.875	4 100	2½ 65	5 127	8¼ 210	13½ 343	9 229	9½ 241	12½ 318	2¾ 56	51.0 329	300 20.7	38 17.2
4 x 3 100 x 80	4.500 x 3.500 114.3 x 88.9	4 100	3 80	5 127	8¼ 210	13½ 343	9 229	10 254	12½ 318	2¾ 56	51.0 329	300 20.7	38 17.2
4 x 4 100 x 100	4.500 x 4.500 114.3 x 114.3	4 100	4 100	6½ 165	10½ 267	17½ 445	11¾ 298	11½ 292	16½ 419	3¼ 83	95.0 613	300 20.7	72 32.7

For Gruvlok Technical Detail Refer to the Gruvlok Catalog or contact your local Anvil sales representative.

www.anvilintl.com

**FIG. 7250 (CONT'D.)**

## SUCTION DIFFUSER

**FIGURE 7250 - SUCTION DIFFUSER**

Nominal Size	O.D.	System Side (Grooved)	Pump Side (Flanged)	C-E	C-O	OAL	OAH	OAW	CLR	T-O	Orifice Cylinder Open Area	Max. Working Pressure	Approx. Wt. Each
In./DN(mm)	In./mm	In./DN(mm)	In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In. Sq./cm. Sq.	PSI/bar	Lbs./Kg
5 x 4	5.563 x 4.500	5	4	6½	10½	17½	11¾	11½	16½	3¼	95.0	300	74
125 x 100	141.3 x 114.3	125	100	165	267	445	298	292	419	83	613	20.7	33.6
5 x 5	5.563 x 5.563	5	5	6½	10½	17½	11¾	12½	16½	3¼	124.0	300	75
125 x 125	141.3 x 141.3	125	125	165	267	445	298	318	419	83	800	20.7	34.0
6 x 3	6.625 x 3.500	6	3	6½	10½	18	11¾	10½	17½	3¼	94.0	300	72
150 x 80	168.3 x 88.9	150	80	165	267	457	298	268	445	83	607	20.7	34.0
6 x 4	6.625 x 4.500	6	4	6½	10½	17½	11¾	11½	16½	3¼	95.0	300	72
150 x 100	168.3 x 114.3	150	100	165	267	445	298	292	419	83	613	20.7	32.7
6 x 5	6.625 x 5.563	6	5	6½	10½	17½	11¾	12½	16½	3¼	124.0	300	74
150 x 125	168.3 x 141.3	150	125	165	267	445	298	318	419	83	800	20.7	33.6
6 x 6	6.625 x 6.625	6	6	7¾	13¼	21½	14¾	13½	20½	4⅛	182.0	300	133
150 x 150	168.3 x 168.3	150	150	197	337	546	375	343	521	124	1.174	20.7	60.3
8 x 5*	8.625 x 5.563	8	5	7¾	13¼	21½	10 <sup>15</sup> <sub>16</sub>	10	19½	4⅛	182.0	300	118
200 x 125	219.1 x 141.3	200	125	197	337	546	278	254	495	124	1.174	20.7	53.5
8 x 6	8.625 x 6.625	8	6	7¾	13¼	21½	14¾	13½	20½	4⅛	182.0	300	118
200 x 150	219.1 x 168.3	200	150	197	337	546	375	343	521	124	1.174	20.7	53.5
8 x 8	8.625 x 8.625	8	8	9	15¼	24½	17½	19	23½	5⅛	283.5	300	190
200 x 200	219.1 x 219.1	200	200	229	387	622	445	483	597	149	1.829	20.7	86.2
10 x 8	10.750 x 8.625	10	8	9	15¼	24½	17½	19	23½	5⅛	283.5	300	203
250 x 200	273.1 x 219.1	250	200	229	387	622	445	483	597	149	1.829	20.7	92.1
10 x 10*	10.750 x 10.750	10	10	17¼	28	19½	22	26	7¾	397.0	300	192	
250 x 250	273.1 x 273.1	250	250	254	438	711	498	559	660	187	2,561	20.7	87.1

## Valves &amp; Accessories

FIG. 7250 (CONT'D.)

SUCTION DIFFUSER

FIGURE 7250 - SUCTION DIFFUSER

Nominal Size	O.D.	System Side (Grooved)	Pump Side (Flanged)	C-E	C-O	OAL	OAH	OAW	CLR	T-O	Orifice Cylinder Open Area	Max. Working Pressure	Approx. Wt. Each
In./DN(mm)	In./mm	In./DN(mm)	In./DN(mm)	In./mm	In. Sq./cm. Sq.	PSI/bar	Lbs./Kg						
12 x 10*	12.750 x 10.750	12	10	10	17½	28	19½	22	26	7½	397.0	300	196
300 x 250	323.9 x 273.1	300	250	254	438	711	498	559	660	187	2,561	20.7	88.9
12 x 12*	12.750 x 12.750	12	12	11	24¼	36	20½	24	34	8	571.0	300	382
300 x 300	323.9 x 323.9	300	300	279	616	914	521	610	864	203	3,684	20.7	173.3
14 x 10*	14.000 x 10.750	14	10	11	24¼	36	20½	24	34	8	571	300	382
350 x 250	355.6 x 273.1	350	250	279	616	914	521	610	864	203	3,684	20.7	173.3
14 x 12*	14.000 x 12.750	14	12	11	24¼	36	20½	24	34	8	571.0	300	382
350 x 300	355.6 x 323.9	350	300	279	616	914	521	610	864	203	3,684	20.7	173.3
14 x 14*	14.000 x 14.000	14	14	12	26¼	39	23	26¼	37	9	993.0	300	467
350 x 350	355.6 x 355.6	350	350	305	667	991	584	667	940	229	6,406	20.7	211.8
16 x 14*	16.000 x 14.000	16	14	12	26¼	39	23	26¼	37	9	993.0	300	467
400 x 350	406.4 x 355.6	400	350	305	667	991	584	667	940	229	6,406	20.7	211.8

\* Fabricated

Other sizes available on special request. Contact Anvil Rep. for ordering information.

Dimensions may vary Contact Anvil Rep. for certified values.

Not for use in copper systems.

Product must be supported by pipe supports (supports not included).

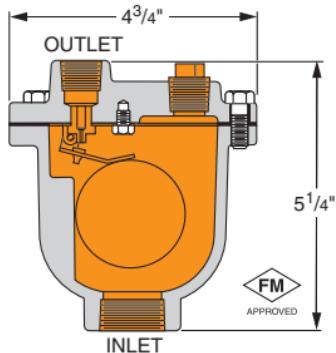
## NOTES:

1. "CLR" Dimension indicates clearance needed for diffuser basket removal.

2. Drain Holes: (End Cap)—¾" NPT for sizes 2½ x 2½ thru 6 x 5,  
-1" NPT for sizes 6 x 6 thru 16 x 14.3. Pipe Support - Use 1¼" SCH. 40 Pipe for 2½" thru 10" pipe & 2" SCH. 40 Pipe  
for 12" & larger diffusers.4. "Orifice Cylinder Open Area" is the total area of the opening in the diffuser basket  
after the pre-filter screen has been removed.

**MODELS GAV-15**

AUTOMATIC AIR VENTS FOR ULTIMATE PERFORMANCE

**MODEL GAV-15 - AUTOMATIC AIR VENT**

Valve Size <i>In./DN(mm)</i>	Maximum Temp. °F/°C	Inlet Size NPT <i>In./DN(mm)</i>	Outlet Size NPT <i>In./DN(mm)</i>	Orifice Size <i>In./DN(mm)</i>	Approx. Wt. Ea. <i>Lbs/Kg</i>
1/2 15	250 120	1/2 15	1/2 15	1/16 2	5 1/2 3
3/4 20	250 120	3/4 20	1/2 15	1/16 2	5 1/2 3
1 25	250 120	1 25	1/2 15	1/16 2	5 1/2 3

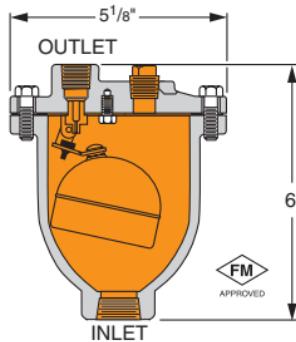
**MODEL GAV-15 - AUTOMATIC AIR VENT**

Type	Max. Water Pressure <i>psi/bar</i>	Max. Temp. °F/°C	Inlet Size <i>In./DN(mm)</i>	Outlet Size NPT <i>In./DN(mm)</i>	Valve Orifice <i>In./mm</i>	Overall			Approx. Wt. Ea. <i>Lbs/Kg</i>
						Height <i>In./mm</i>	Width <i>In./mm</i>	Length <i>In./mm</i>	
GAV-15	150	250	1/2, 3/4 & 1	3/8	1/16	5 1/4	4 3/4	4 3/4	5 1/2
	10	120	15, 20 & 25	10	2	130	100	100	2.5

# Valves & Accessories

## MODELS GAV-30

AUTOMATIC AIR VENTS FOR ULTIMATE PERFORMANCE

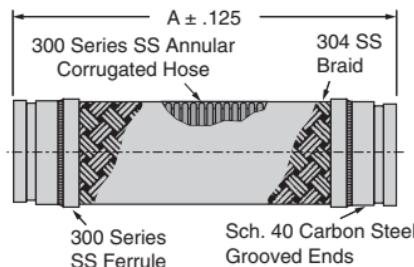


MODEL GAV-30 - AUTOMATIC AIR VENT					
Valve Size <i>In./DN(mm)</i>	Maximum Temp. °F/°C	Inlet Size NPT <i>In./DN(mm)</i>	Outlet Size NPT <i>In./DN(mm)</i>	Orifice Size <i>In./DN(mm)</i>	Approx. Wt. Ea. <i>Lbs/Kg</i>
1/2	250	1/2	1/2	1/16	8
15	120	15	15	2	3
3/4	250	3/4	1/2	1/16	8
20	120	20	15	2	3

MODEL GAV-30 - AUTOMATIC AIR VENT									
Type	Max. Water Pressure <i>psi/bar</i>	Max. Temp. °F/°C	Inlet Size <i>In./DN(mm)</i>	Outlet Size NPT <i>In./DN(mm)</i>	Valve Orifice <i>In./mm</i>	Overall			Approx. Wt. Ea. <i>Lbs/Kg</i>
						Height <i>In./mm</i>	Width <i>In./mm</i>	Length <i>In./mm</i>	
GAV-30	300 20.7	250 120	1/2, 3/4 & 1 15, 20 & 25	1/2 15	1/16 2	6 150	5 1/8 125	5 1/8 125	7 1/2 3.4

**FIG. AF21-GG**

GROOVED ENDS FLEX CONNECTOR



See Installation & Assembly directions on  
pages 192-193.

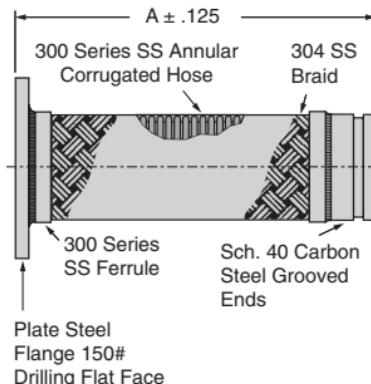
AF21-GG - GRxGR FLEX CONNECTORS							
Nominal Size <i>In./DN(mm)</i>	Pipe O.D. <i>In./mm</i>	Model or 10 dig. #	A <i>In./mm</i>	Pressure 70°F <i>psi/bar</i>	Parallel Offset *		Approx. Wt. Ea. <i>Lbs./kN</i>
					Permanent <i>In./mm</i>	Intermittent <i>In./mm</i>	
2	2.375	AF0390232007	12	450	1 1/4	3/8	3.9
50	60.3		304.8	31.0	31.8	9.5	1.8
2 1/2	2.875	AF0390232106	12	300	1 1/4	3/8	4.7
65	73.0		304.8	20.7	31.8	9.5	2.1
3	3.500	AF0390232031	12	275	3/4	1/4	6.1
80	88.9		304.8	19.0	19.1	6.4	2.8
4	4.500	AF0390232114	14	270	1/2	1/4	9.3
100	114.3		355.6	18.6	12.7	6.4	4.2
5	5.563	AF0390232122	16	225	7/8	3/8	11.8
125	141.3		406.4	15.5	22.2	9.5	5.8
6	6.625	AF0390232130	16	165	5/8	1/4	16.8
150	168.3		406.4	11.4	15.9	6.4	7.6
8	8.625	AF0390232148	16	155	1/2	1/4	23.5
200	219.1		406.4	10.7	12.7	6.4	10.7
10	10.750	AF0390232155	20	150	1/2	1/4	44.1
250	273.1		508.0	10.3	12.7	6.4	20.0
12	12.750	AF0390232163	20	145	1/2	1/4	51.5
300	323.9		508.0	10.0	12.7	6.4	23.4

\* See Motion Classification to the left for additional information.

## Valves &amp; Accessories

FIG. AF21-GF

CLASS 150 FLANGED X GROOVED FLEX CONNECTOR



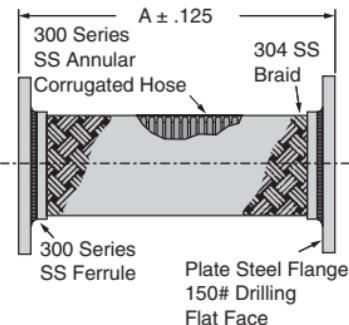
See Installation & Assembly directions on  
pages 192-193.

AF21-GF - GRxFL FLEX CONNECTORS								
Nominal Size <i>In./DN(mm)</i>	Flange O.D. <i>In./mm</i>	Pipe O.D. <i>In./mm</i>	Model or 10 dig. #	A <i>In./mm</i>	Pressure 70°F <i>psi/bar</i>	Parallel Offset		Approx. Wt. Ea. <i>Lbs./kN</i>
						Permanent <i>In./mm</i>	Intermittent <i>In./mm</i>	
2	6	2.375	AF0390232197	12	450	1 $\frac{7}{8}$	5 $\frac{1}{8}$	7.2
50	152.4	60.3		304.8	31.0	47.6	15.9	3.3
2½	7	2.875	AF0390232213	12	300	1 $\frac{1}{8}$	5 $\frac{1}{8}$	8.5
65	177.8	73.0		304.8	20.7	41.3	15.9	3.9
3	7½	3.500	AF0390232171	12	275	1 $\frac{1}{8}$	1 $\frac{1}{2}$	10.4
80	190.5	88.9		304.8	19.0	28.6	12.7	4.7
4	9	4.500	AF0390232189	12	270	5 $\frac{1}{8}$	1 $\frac{1}{4}$	14.0
100	228.6	114.3		304.8	18.6	15.9	6.4	6.4
5	10	5.563	AF0390232247	14	225	7 $\frac{1}{8}$	3 $\frac{1}{8}$	18.4
125	254.0	141.3		355.6	15.5	22.2	9.5	8.3
6	11	6.625	AF0390232254	14	165	3 $\frac{1}{4}$	3 $\frac{1}{8}$	23.7
150	279.4	168.3		355.6	11.4	19.1	9.5	10.8
8	13½	8.625	AF0390232262	15	155	1 $\frac{1}{2}$	1 $\frac{1}{4}$	39.6
200	342.9	219.1		381.0	10.7	12.7	6.4	18.0
10	16	10.750	AF0390232270	16	150	5 $\frac{1}{8}$	1 $\frac{1}{4}$	61.5
250	406.4	273.1		406.4	10.3	15.9	6.4	27.9
12	19	12.750	AF0390232288	17	145	1 $\frac{1}{2}$	1 $\frac{1}{4}$	81.0
300	482.6	323.9		431.8	10.0	12.7	6.4	36.7

\* See Motion Classification on previous page for additional information.

**FIG. AF21-FF**

CLASS 150 FLANGED X CLASS 150  
FLANGED FLEX CONNECTOR



See Installation & Assembly directions on  
pages 192-193.

Anvil also provides AnvilFlex™ Increaseres  
contact your Anvil Rep. for additional  
information

**AF21-FF - FLxFL FLEX CONNECTORS**

Nominal Size	Flange O.D.	Pipe O.D.	Model or 10 dig. #	A	Pressure 70°F	Parallel Offset		Approx. Wt. Ea.
						Permanent	Intermittent	
In./DN(mm)	In./mm	In./mm		In./mm	psi/bar	In./mm	In./mm	Lbs./kN
2	6	2.375	AF0390232387	9	450	1 1/8	3/8	10.0
50	152.4	60.3		228.6	31.0	28.6	9.5	4.5
2 1/2	7	2.875	AF0390232395	9	300	1	3/8	12.0
65	177.8	73.0		228.6	20.7	25.4	9.5	5.4
3	7 1/2	3.500	AF0390232403	9	275	5/8	1/4	14.0
80	190.5	88.9		228.6	19.0	15.9	6.4	6.4
4	9	4.500	AF0390232429	9	270	1/2	1/4	19.0
100	228.6	114.3		228.6	18.6	12.7	6.4	8.6
5	10	5.563	AF0390232437	11	225	3/4	3/8	25.0
125	254.0	141.3		279.4	15.5	19.1	9.5	11.3
6	11	6.625	AF0390232445	11	165	5/8	1/4	30.0
150	279.4	168.3		279.4	11.4	15.9	6.4	13.6
8	13 1/2	8.625	AF0390232452	12	155	1/2	1/4	54.0
200	342.9	219.1		304.8	10.7	12.7	6.4	24.5
10	16	10.750	AF0390232460	13	150	1/2	1/4	75.0
250	406.4	273.1		330.2	10.3	12.7	6.4	34.0
12	19	12.750	AF0390232478	14	145	1/2	1/4	105.0
300	482.6	323.9		355.6	10.0	12.7	6.4	47.6

\* See Motion Classification on previous page for additional information.

# High Pressure System

**FIG. 7004 HPR®**

COUPLING

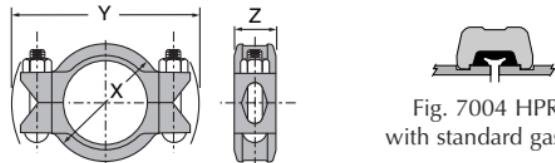


Fig. 7004 HPR®  
with standard gasket.

**FIGURE 7004 - HPR COUPLING**

Nom. Size	O.D.	Max. Wk. Pressure	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts		Approx. Wt. Ea.
					X In./mm	Y In./mm	Z In./mm	Qty.	Size In./mm	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm	In./mm			Lbs./Kg
2 50	2.375 60.3	1200 82.8	5,316 23.65	0 - 1/8 0 - 3.2	3 5/8 92	6 1/4 159	1 1/8 48	2	5/8 x 2 3/4 -	3.9 1.8
2 1/2 65	2.875 73.0	1200 82.8	7,790 34.65	0 - 1/8 0 - 3.2	4 1/4 108	6 7/8 175	1 1/8 48	2	5/8 x 3 1/2 M16 x 85	4.6 2.1
3 80	3.500 88.9	1200 82.8	11,545 51.36	0 - 1/8 0 - 3.2	4 7/8 124	7 1/2 191	1 1/8 48	2	5/8 x 3 1/2 M16 x 85	5.2 2.4
4 100	4.500 114.3	1200 82.8	19,085 84.90	0 - 1/4 0 - 6.4	6 1/4 159	9 1/2 241	2 1/4 57	2	3/4 x 4 1/2 M20 x 110	8.6 3.9
5 125	5.563 141.3	1200 82.8	29,167 129.74	0 - 1/4 0 - 6.4	7 1/2 191	11 279	2 1/4 57	2	7/8 x 5 1/2 M22 x 150	14.0 6.4
6 150	6.625 168.3	1200 82.8	41,366 184.00	0 - 1/4 0 - 6.4	8 3/4 222	12 1/8 308	2 1/4 57	2	7/8 x 5 1/2 M22 x 150	15.5 7.0
8 200	8.625 219.1	1000 68.9	58,426 259.89	0 - 1/4 0 - 6.4	11 1/8 283	14 7/8 378	2 5/8 67	2	1 x 5 1/2 -	25.6 11.6
10 250	10.750 273.1	800 55.2	72,610 322.99	0 - 1/4 0 - 6.4	13 1/2 343	17 432	2 5/8 67	2	1 x 6 1/2 -	32.3 14.7
12 300	12.750 323.9	800 55.2	102,141 454.35	0 - 1/4 0 - 6.4	15 1/8 403	19 1/4 489	2 5/8 67	2	1 x 6 1/2 -	43.9 19.9

For additional details, see coupling data chart notes on page 264.

Not for use in copper systems.

## High Pressure Fittings

**FIG. 7004 EG®**

END GUARD® COUPLING

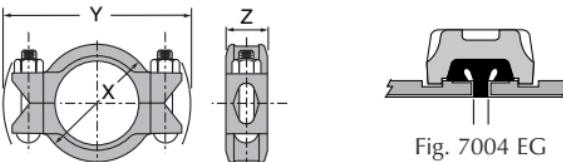


Fig. 7004 EG  
with "EG" gasket.

FIGURE 7004 - END GUARD (EG) COUPLING

Nominal Size	O.D.	Max. Wk. Pressure	Max. End Load	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts	Approx. Wt. Ea.
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm	Qty.	Size	In./mm Lbs./Kg
2	2.375	2500	11,075	0 - 1/8	3 1/8	6 1/4	1 1/8	2	5/8 x 2 3/4 4.1
50	60.3	172.4	49.27	0 - 3.2	92	159	48	-	1.9
2 1/2	2.875	2500	16,230	0 - 1/8	4 1/4	6 7/8	1 1/8	2	5/8 x 3 1/2 5.1
65	73.0	172.4	72.19	0 - 3.2	108	175	48	M16 x 85	2.3
3	3.500	2500	24,053	0 - 1/8	4 1/8	7 1/2	1 1/8	2	5/8 x 3 1/2 5.5
80	88.9	172.4	106.99	0 - 3.2	124	191	48	M16 x 85	2.5
4	4.500	2500	39,761	0 - 1/4	6 1/4	9 1/2	2 1/4	2	3/4 x 4 1/2 9.0
100	114.3	172.4	176.86	0 - 6.4	159	241	57	M16 x 85	4.1
6	6.625	2000	68,943	0 - 1/4	8 3/4	12 1/8	2 1/4	2	7/8 x 5 1/2 15.5
150	168.3	137.9	306.67	0 - 6.4	222	308	57	M22 x 150	7.0
8	8.625	1500	87,639	0 - 1/4	11 1/8	14 7/8	2 5/8	2	1 x 5 1/2 25.6
200	219.1	103.4	389.84	0 - 6.4	283	378	67	-	11.6
10	10.750	1250	113,453	0 - 1/4	13 1/2	17	2 5/8	2	1 x 6 1/2 32.3
250	273.1	86.2	504.66	0 - 6.4	343	432	67	-	14.7
12	12.750	1250	159,595	0 - 1/4	15 1/8	19 1/4	2 5/8	2	1 x 6 1/2 43.9
300	323.9	86.2	709.92	0 - 6.4	403	489	67	-	19.9

For additional details, see coupling data chart notes on page 264.

Not for use in copper systems.

**FIG. 7068 EG**

HIGH PRESSURE CROSS

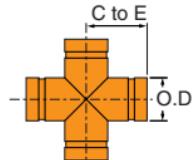


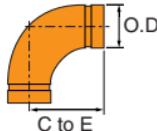
Fig. 7068 EG  
HIGH PRESSURE CROSS

Nom. Size	O.D.	Center To-End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 1/4	3.9
50	60.3	83	1.8
2 1/2	2.875	3 3/4	6.8
65	73.0	95	3.1
3	3.500	4 1/4	11.5
80	88.9	108	5.2
4	4.500	5	19.3
100	114.3	127	8.8
6	6.625	6 1/2	46.0
150	168.3	165	20.9

## High Pressure System

**FIG. 7050 EG**

HIGH PRESSURE 90° LR ELBOW



**FIGURE 7050 EG,  
HIGH PRESSURE 90° LR ELBOW**

Nom. Size	O.D.	Center To-End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 1/4	2.5
50	60.3	83	1.1
2 1/2	2.875	3 3/4	4.2
65	73.0	95	1.9
3	3.500	4 1/4	6.0
80	88.9	108	2.7
4	4.500	5	11.0
100	114.3	127	5.0
6	6.625	6 1/2	27.2
150	168.3	165	12.4
8	8.625	*	*
200	219.1	*	*
10	10.750	*	*
250	273.0	*	*
12	12.750	*	*
300	323.9	*	*

\*Contact an Anvil Representative for more information.

**FIG. 7051 EG**

HIGH PRESSURE 45° LR ELBOW

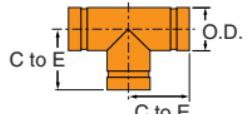


**FIGURE 7051 EG,  
HIGH PRESSURE 45° LR ELBOW**

Nom. Size	O.D.	Center To-End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	2	1.8
50	60.3	51	0.8
2 1/2	2.875	2 1/4	2.9
65	73.0	57	1.3
3	3.500	2 1/2	4.3
80	88.9	64	2.0
4	4.500	3	7.5
100	114.3	76	3.4
6	6.625	3 1/2	16.5
150	168.3	89	7.5

**FIG. 7022 EG**

HIGH PRESSURE HEADER TEE

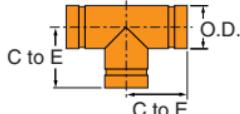


**FIG. 7022 EG  
HIGH PRESSURE HEADER TEE**

Nom. Size	O.D.	Center To-End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	6 1/2	4.9
50	60.3	165	2.2
2 1/2	2.875	5	3.6
65	73.0	127	1.6

**FIG. 7060 EG**

HIGH PRESSURE TEE

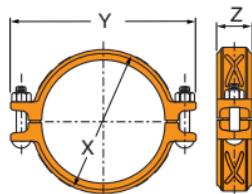


**FIGURE 7060 EG  
HIGH PRESSURE TEE**

Nom. Size	OD	Center To-End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 1/4	3.3
50	60.3	83	1.5
2 1/2	2.875	3 3/4	5.1
65	73.0	95	2.3
3	3.500	4 1/4	9.3
80	88.9	108	4.2
4	4.500	5	15.9
100	114.3	127	7.2
6	6.625	6 1/2	38.5
150	168.3	165	17.5

**FIG. 7400**

RIGIDLITE® COUPLING

**FIGURE 7400 - RIGIDLITE COUPLING**

Nominal Size	O.D.	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts.		Specified Torque §		Approx Wt. Ea.
			X	Y	Z	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm		Ft. -Lbs./N-M	Lbs./Kg	
2	2.375	0 -1/8	3 1/4	5 1/2	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60	1.6 0.7
50	60.3	0 - 3.2	83	140	44					
2 1/2	2.875	0 -1/8	3 7/8	5	1 3/4	2	5/8 x 2 1/4 M10 x 57	30 40	45 60	1.9 0.9
65	73.0	0 - 3.2	98	127	44					
3	3.500	0 -1/8	4 1/2	6 3/4	1 3/4	2	5/8 x 2 3/4 M10 x 70	30 40	45 60	2.1 1.0
80	88.9	0 - 3.2	114	171	44					
4	4.500	0 -1/4	5 5/8	7 3/4	1 7/8	2	5/8 x 2 3/4 M10 x 70	30 40	45 60	3.1 1.4
100	114.3	0 - 6.4	143	197	48					
5	5.563	0 -1/4	6 7/8	9 1/4	2	2	1/2 x 3 M12 x 76	80 110	100 150	4.6 2.1
125	141.3	0 - 6.4	175	235	51					
6	6.625	0 -1/4	7 1/8	10 1/8	2	2	1/2 x 3 M12 x 76	80 110	100 150	5.5 2.5
150	168.3	0 - 6.4	200	264	51					
8	8.625	0 -1/8	10 1/4	12 3/4	2 3/8	2	1/2 x 3 M12 x 76	80 110	100 150	8.4 3.8
200	219.1	0 - 3.2	260	324	60					

§ – For additional Bolt Torque information on page 202.

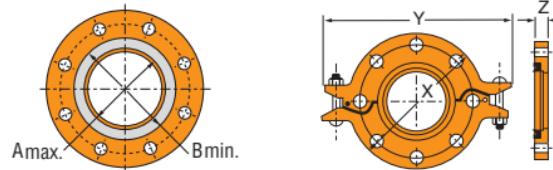
see "Coupling Data Chart Notes" on page 264.

See Installation &amp; Assembly directions on pages 158-159.

## Advanced Copper Method

**FIG. 7012 (NOTES CONTINUED ON NEXT PAGE)**

GRUVLOK FLANGES FOR GRUVLOK ADVANCED COPPER METHOD

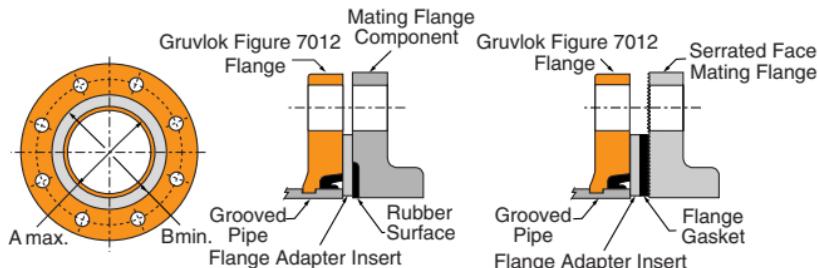
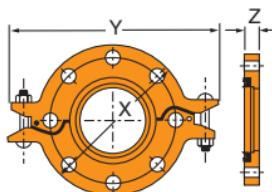


GRUVLOK FIGURE 7012 - FLANGE: ANSI CLASS 150 OR ISO PN10 OR PN16 BOLT PATTERNS

Nom. Size	O.D.	Max. Working Pressure▼	Max. End Load▼	Latch Bolt		Range Dimensions			Sealing Surface		Mating Flange Bolts			Approx. Wt. Ea.		
				Latch* Bolt Size	Specified Torque \$	Min.	Max.	X	Y	Z	A Max.	B Min.	Qty. ANSI	Size (ANSI)		
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Ft.-Lbs/N-M	In./mm	In./mm	In./mm	In./mm	In./mm	PN10 (16)	In. (ISO) mm	Ft.-Lbs/N-M	Lbs./Kg		
2	2.375	300	1,329	3/8 x 2 3/4	30	45	6 1/4	8 5/8	3/4	2 3/8	37/16	4	5/8 x 2 3/4	110	140	4.2
50	60.3	20.7	5.91	M10 x 70	40	60	159	213	19	60	87	4	M16 x 70	149	190	1.9
2 1/2	2.875	300	1,948	3/8 x 2 3/4	30	45	7	9 1/2	3/4	2 7/8	4	4	5/8 x 2 3/4	110	140	4.6
65	73.0	20.7	8.66	M10 x 70	40	60	178	241	19	73	102	-	M16 x 70	149	190	2.1
3	3.500	300	2,886	3/8 x 2 3/4	30	45	7 1/8	10 1/2	3/4	3 1/2	4 9/16	4	5/8 x 2 3/4	110	140	6.0
80	88.9	20.7	12.84	M10 x 70	40	60	200	267	19	89	116	8	M16 x 70	149	190	2.7
4	4.500	300	4,771	3/8 x 2 3/4	30	45	9	11 1/2	3/4	4 1/2	5 9/16	8	5/8 x 2 3/4	110	140	6.3
100	114.3	20.7	21.22	M10 x 70	40	60	229	292	19	114	141	8	M16 x 70	149	190	2.9
5	5.563	300	7,292	3/8 x 2 3/4	30	45	10	12 1/2	7/8	5 9/16	6 3/4	8	3/4 x 2 7/8	220	250	8.8
125	141.3	20.7	32.44	M10 x 70	40	60	254	318	22	141	171	-	-	298	339	4.0
6	6.625	300	10,341	3/8 x 2 3/4	30	45	11	14	7/8	6 5/8	7 13/16	8	3/4 x 3 1/8	220	250	9.6
150	168.3	20.7	46.00	M10 x 70	40	60	279	356	22	168	198	8	M20 x 80	298	339	4.4
8	8.625	300	17,528	3/8 x 2 3/4	30	45	13 1/2	16 1/2	1	8 5/8	10	8	3/4 x 3 1/4	220	250	15.6
200	219.1	20.7	77.97	M10 x 70	40	60	343	419	25	219	254	8 (12)	M20 x 80	298	339	7.1

**FIG. 7012 (NOTES CONTINUED FROM PREVIOUS PAGE)**

## GRUVLOK FLANGES FOR GRUVLOK ADVANCED COPPER METHOD



+ PN 16 uses M24 x 90 (PN) Dimensions for bolt circle PN 10 & 16 Flange

\* Available in ANSI or metric bolt sizes only as indicated.

▼ Based on use with standard wall pipe.

§ – For additional Bolt Torque information see page 202.

See "Coupling Data Chart Notes" on page 264.

See Installation & Assembly directions on pages 164-169.

The Gruvlok Flange bolt hole pattern conforms to ANSI Class 150 and Class 125 flanges.

Effective sealing area of mating flange must be free from gouges, undulations or deformities of any type to ensure proper sealing of the gasket.

To avoid interference issues, flanges cannot be assembled directly to Series 7700 butterfly valve. Flange can be assembled to one side of series 7500 and 7600 valve only.

Gruvlok Flange adapter insert required when mating to rubber surfaces or serrated faced mating flanges.

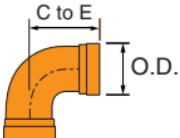
Mating flange bolts must be at least Intermediate Strength Bolting per ASME B16.5. Bolts with material properties equal or greater than SAE J429 Grade 5 are acceptable.

Refer to Gruvlok Products Catalog or Anvil's web site for more information on installing this flange

## Advanced Copper Method

**FIG. 7550**

90° ELBOW



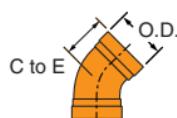
**FIGURE 7550 - 90° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 $\frac{1}{4}$	0.9
50	60.3	83	0.4
2 $\frac{1}{2}$	2.875	3 $\frac{3}{4}$	1.5
65	73.0	95	0.7
3	3.500	4 $\frac{1}{4}$	2.4
80	88.9	108	1.1
4	4.500	5	5.5
100	114.3	127	2.5
5	5.563	5 $\frac{1}{2}$	9.3
125	141.3	140	4.2
6	6.625	6 $\frac{1}{2}$	17.6
150	168.3	165	8.0
8	8.625	12	29.4
200	219.1	305	13.3

8" fittings are copper coated stainless steel.

**FIG. 7551**

45° ELBOW



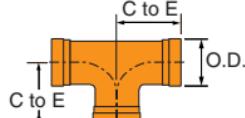
**FIGURE 7551 - 45° ELBOW**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	2 $\frac{1}{8}$	0.6
50	60.3	54	0.3
2 $\frac{1}{2}$	2.875	2 $\frac{3}{8}$	1.1
65	73.0	60	0.5
3	3.500	2 $\frac{5}{8}$	1.6
80	88.9	67	0.7
4	4.500	3 $\frac{1}{8}$	3.5
100	114.3	86	1.6
5	5.563	3 $\frac{1}{4}$	6.1
125	141.3	83	2.8
6	6.625	3 $\frac{1}{2}$	11.7
150	168.3	89	5.3
8	8.625	7 $\frac{1}{2}$	19.4
200	219.1	191	8.8

8" fittings are copper coated stainless steel.

**FIG. 7560**

TEES



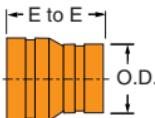
**FIGURE 7560 - TEES**

Nom. Size	O.D.	Center to End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 $\frac{1}{4}$	1.7
50	60.3	83	0.8
2 $\frac{1}{2}$	2.875	3 $\frac{3}{4}$	2.5
65	73.0	95	1.1
3	3.500	4 $\frac{1}{4}$	3.5
80	88.9	108	1.6
4	4.500	5	7.3
100	114.3	127	3.3
5	5.563	5 $\frac{1}{2}$	7.9
125	141.3	140	3.6
6	6.625	6 $\frac{1}{2}$	13.4
150	168.3	165	6.1
8	8.625	7 $\frac{3}{4}$	41.7
200	219.1	197	18.9

8" fittings are copper coated stainless steel.

**FIG. 7572**

(GR X GR) CONCENTRIC REDUCER

**FIGURE 7572 - (GR X GR) CONCENTRIC REDUCER**

Nom. Size <i>In./DN(mm)</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2½ x 2 65 x 50	3¼ 83	0.6 0.3
3 x 2 80 x 50	3⅜ 98	1.0 0.5
3 x 2½ 80 x 65	3⅝ 92	0.9 0.4
4 x 2 100 x 50	5 127	2.2 1.0
4 x 2½ 100 x 65	4¾ 121	2.0 0.9
4 x 3 100 x 80	4¾ 121	2.0 0.9

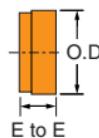
8" fittings fabricated upon request.

Contact your Anvil Representative for more information.

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7574**

END CAP

**FIGURE 7574 - END CAPS**

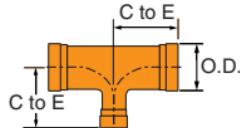
Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	End to End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2 50	2.375 60.3	1¼ 32	0.3 0.1
2½ 65	2.875 73.0	1¼ 32	0.4 0.2
3 80	3.500 88.9	1¼ 32	0.6 0.3
4 100	4.500 114.3	1¼ 32	1.0 0.5
5 125	5.563 141.3	1¼ 32	2.2 1.0
6 150	6.625 168.3	1¼ 32	2.8 1.3
8 200	8.625 219.1	4 203	11.0 5.0

8" fittings are copper coated stainless steel.

## Advanced Copper Method

**FIG. 7561A**

(GR x GR x GR) REDUCING TEE



**FIGURE 7561A - (GR x GR x GR) REDUCING TEE**

Nominal Size	Center to End	Cup	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2½ x 2½ x 2 65 x 65 x 50	7½ 191	3¾ 95	1.8 0.8
3 x 3 x 2 80 x 80 x 50	8½ 216	4¼ 108	2.7 1.2
3 x 3 x 2½ 80 x 80 x 65	8½ 216	4¼ 108	2.1 1.0
4 x 4 x 2 100 x 100 x 50	10 254	5 127	4.8 2.2
4 x 4 x 2½ 100 x 100 x 65	10 254	5 127	4.9 2.2
4 x 4 x 3 100 x 100 x 80	10 254	5 127	5.1 2.3

Nominal Size	Center to End	Cup	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
5 x 5 x 3 125 x 125 x 80	11 279	5½ 140	7.5 3.4
5 x 5 x 4 125 x 125 x 100	11 279	5½ 140	7.8 3.5
6 x 6 x 2½ 150 x 150 x 65	13 330	6½ 165	11.5 5.2
6 x 6 x 3 150 x 150 x 80	13 330	6½ 165	11.7 5.3
6 x 6 x 4 150 x 150 x 100	13 330	6½ 165	12.1 5.5
6 x 6 x 5 150 x 150 x 125	13 330	6½ 165	12.4 5.6

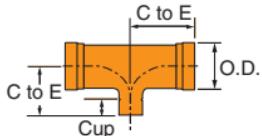
Nominal Size	Center to End	Cup	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
8 x 8 x 2½ 200 x 200 x 65	15 381	7¾ 197	18 8.2
8 x 8 x 3 200 x 200 x 80	15 381	7¾ 197	18.2 8.3
8 x 8 x 4 200 x 200 x 100	15 381	7¾ 197	18.4 8.3
8 x 8 x 5 200 x 200 x 125	15 381	7¾ 197	18.8 8.5
8 x 8 x 6 200 x 200 x 150	15 381	7¾ 197	19 8.6

8" fittings are copper coated stainless steel.

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7564A**

(GR x GR x CUP) REDUCING TEE

**FIGURE 7564A - (GR x GR x CUP) REDUCING TEE**

Nom. Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Cup <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2 x 2 x 3/4 50 x 50 x 20	6 1/2 165	3 1/4 83	1.0 0.5
2 x 2 x 1 50 x 50 x 25	6 1/2 165	3 1/4 83	1.0 0.5
2 x 2 x 1 1/4 50 x 50 x 32	6 1/2 165	3 1/4 83	1.1 0.5
2 x 2 x 1 1/2 50 x 50 x 40	6 1/2 165	3 1/4 83	1.1 0.5
2 1/2 x 2 1/2 x 3/4 65 x 65 x 80	7 1/2 191	3 3/4 95	1.6 0.7
2 1/2 x 2 1/2 x 1 65 x 65 x 25	7 1/2 191	3 3/4 95	1.7 0.8
2 1/2 x 2 1/2 x 1 1/4 65 x 65 x 32	7 1/2 191	3 3/4 95	1.7 0.8

Nom. Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Cup <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2 1/2 x 2 1/2 x 1 1/2 65 x 65 x 40	7 1/2 191	3 3/4 95	1.7 0.8
2 1/2 x 2 1/2 x 2 65 x 65 x 50	7 1/2 191	3 3/4 95	1.8 0.8
3 x 3 x 3/4 80 x 80 x 20	8 1/2 216	4 1/4 108	2.5 1.1
3 x 3 x 1 80 x 80 x 25	8 1/2 216	4 1/4 108	2.5 1.1
3 x 3 x 1 1/4 80 x 80 x 32	8 1/2 216	4 1/4 108	2.5 1.1
3 x 3 x 1 1/2 80 x 80 x 40	8 1/2 216	4 1/4 108	2.6 1.2
3 x 3 x 2 80 x 80 x 50	8 1/2 216	4 1/4 108	2.7 1.2

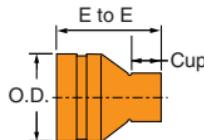
Nom. Size <i>In./DN(mm)</i>	Center to End <i>In./mm</i>	Cup <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
4 x 4 x 3/4 100 x 100 x 20	10 254	5 127	4.5 2.0
4 x 4 x 1 100 x 100 x 25	10 254	5 127	4.6 2.1
4 x 4 x 1 1/4 100 x 100 x 32	10 254	5 127	4.7 2.1
4 x 4 x 1 1/2 100 x 100 x 40	10 254	5 127	4.7 2.1
4 x 4 x 2 100 x 100 x 50	10 254	5 127	4.8 2.2

See Fitting Size Chart on page 148 for O.D. sizes

## Advanced Copper Method

**FIG. 7575**

(GR X CUP) REDUCING ADAPTER

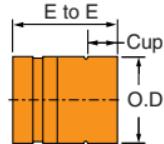


**FIGURE 7575 - (GR X CUP) REDUCING ADAPTER**

Nom. Size	End to End	Cup	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2 x 1	3	7/8	0.4
50 x 25	76	23	0.2
2 x 1 1/4	3	15/16	0.4
50 x 32	76	25	0.2
2 x 1 1/2	2 7/8	1 1/16	0.4
50 x 40	73	28	0.2
2 1/2 x 1	3 1/2	7/8	0.6
65 x 25	89	23	0.3
2 1/2 x 1 1/4	3 1/2	15/16	0.6
65 x 32	89	25	0.3
2 1/2 x 1 1/2	3 1/2	1 1/16	0.7
65 x 40	89	28	0.3
2 1/2 x 2	3 1/4	15/16	0.7
65 x 50	83	34	0.3
3 x 1 1/2	3 7/8	1 1/16	1.1
80 x 40	98	28	0.5
3 x 2	3 7/8	15/16	1.0
80 x 50	98	34	0.5
4 x 2	5	15/16	2.2
100 x 50	127	34	1.0

**FIG. 7582**

TRANSITION FITTING



**FIGURE 7582 - TRANSITION FITTING**

Nominal Size	O.D.	End to End	Cup	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
2	2.375	2 3/4	1 3/8	0.4
50	60.3	70	35	0.2
2 1/2	2.875	3	1 1/2	0.6
65	73.0	76	38	0.3
3	3.500	3 7/16	1 11/16	1.0
80	88.9	87	42	0.5
4	4.500	4 7/16	2 3/16	2.0
100	114.3	112	55	0.9
5	5.563	5 7/16	2 5/8	3.3
125	141.3	138	67	1.5
6	6.625	6 5/8	3 1/8	5.3
150	168.3	162	79	2.4

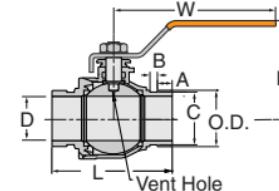
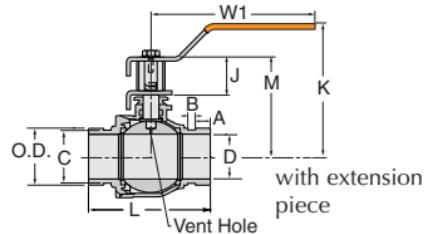
See Fitting Size Chart on page 148 for O.D. sizes

**SERIES 7500B**

GROOVED-END BRONZE BALL VALVE - FULL PORT



FULL PORT

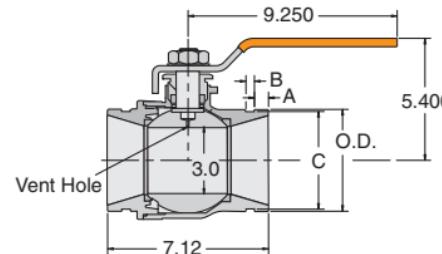
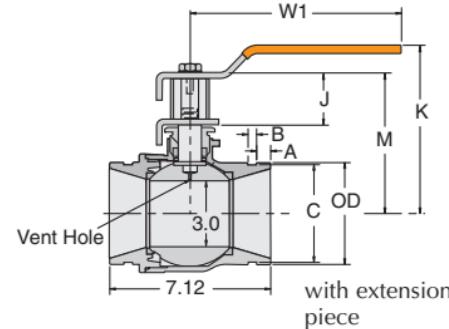
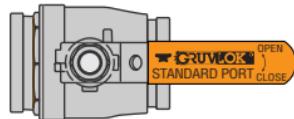
**SERIES 7500B - FULL PORT - DIMENSIONS**

Nominal Size	O.D.	A	B	C	D	H	J	K	L	M	W	W1
In./DN(mm)	In./mm	In./mm										
1½ 40	1.910 48.5	5/8	5/16	1¾	1½	2¹¹/₁₆ 67.8	2¼	4¾ 120.9	4¹/₄ 108.0	3⁵/₈ 91.4	5¹/₈ 129.8	6⁵/₁₆ 159.8
	1.888 48.0	16.0	7.9	45.1	38.1							
2 50	2.375 60.3	5/8	5/16	2¼	2	3⁹/₁₆ 90.9	2¼	5¹¹/₁₆ 144.0	5¹/₁₆ 128.5	4½ 114.6	6.29 159.8	6⁵/₁₆ 159.8
	2.365 60.1	16.0	7.9	57.2	50.8							
2½ 65	2.876 73.1	5/8	5/16	2¹¹/₁₆ 69.1	2½	4¹⁵/₁₆ 126.0	2¼	7¹/₁₆ 179.1	6¹/₈ 155.4	5¾ 146.6	9¼ 235.0	9¼ 235.0
	2.870 72.9	16.0	7.9	69.1	63.5							
3 80	3.500 88.9	5/8	5/16	3⁵/₄ 84.9	3	5⁷/₁₆ 137.2	2¼	7½ 190.5	7 177.8	6¹/₄ 159.5	9¼ 235.0	9¼ 235.0
	3.490 88.6	16.0	7.9	84.9	76.2							

# Advanced Copper Method

## SERIES 7500B

GROOVED-END BRONZE BALL VALVE - STANDARD PORT 4"



### SERIES 7500B - STANDARD PORT 4" - DIMENSIONS

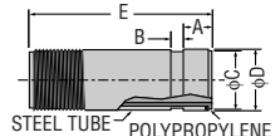
Nominal Size	O.D.	A	B	C	J	K	L	M	W1
In./DN(mm)	In./mm	In./mm							
4	4.545	$\frac{5}{8}$	$\frac{3}{8}$	$4\frac{5}{16}$	$2\frac{1}{4}$	$7\frac{1}{2}$	$7\frac{1}{8}$	$6\frac{1}{4}$	$9\frac{1}{4}$
	115.4								
100	4.469	16.0	9.5	109.5	57.1	190.5	180.8	159.5	235.0
	113.5								

For Gruvlok Technical Detail Refer to the Gruvlok Catalog or contact your local Anvil sales representative.

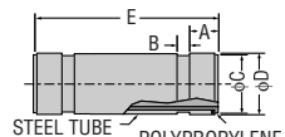
[www.anvilintl.com](http://www.anvilintl.com)

## FIG. 7088, FIG. 7089 &amp; FIG. 7090

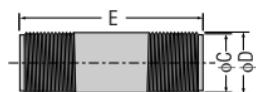
GRUVLOK DI-LOK® NIPPLE  
DI-ELECTRIC PIPE CONNECTION



**FIG. 7088**  
GROOVE BY THREAD



**FIG. 7089**  
GROOVE BY GROOVE



**FIG. 7090**  
THREAD BY THREAD

FIGURE 7088, 7089 & 7090 - DI-LOK® NIPPLES

Nom. IPS Pipe Size	O.D.	A +/- .030 +/- .76	B +/- .030 +/- .76	C Actual	Tolerance +0.000	D Actual	Tolerance	E +/- .090 +/- 2.29
NIPS/DN	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm
3/4 19	1.050 26.7	n/a	n/a	0.881 22	n/a	1.050 26.7	+.005/-0.00 .13/-0.00	3.000 76
1 25	1.315 33.7	n/a	n/a	1.114 28	n/a	1.315 33.7	+.005/-0.00 .13/-0.00	4.000 102
1 1/4 32	1.660 42.4	n/a	n/a	1.458 37	n/a	1.660 42.4	+.006/-0.00 .15/-0.00	4.000 102
1 1/2 40	1.900 48.3	n/a	n/a	1.697 43	n/a	1.900 48.3	+.006/-0.00 .15/-0.00	4.00 102
2 50	2.375 60.3	0.625 15.88	0.312 7.92	2.250 57	-0.015 -.37	2.375 60.3	.007/-0.00 .18/-0.00	4.000 102
2 1/2 65	2.875 73.0	0.625 15.88	0.312 7.92	2.720 69	-0.018 -.45	2.875 73.0	.008/-0.00 .20/-0.00	6.000 152
3 80	3.500 88.9	0.625 15.88	0.312 7.92	3.344 85	-0.018 -.45	3.500 88.9	.010/-0.00 .25/-0.00	6.000 152
4 100	4.500 114.3	0.625 15.88	0.375 9.53	4.334 110	-0.020 -.50	4.500 114.3	.013/-0.00 .33/-0.00	6.000 152
5 125	5.563 141.3	0.625 15.88	0.375 9.53	5.395 137	-0.022 -.55	5.563 141.3	.010 .25	6.000 152
6 150	6.625 168.3	0.625 15.88	0.375 9.53	6.455 164	-0.022 -.55	6.625 168.3	.015 .38	6.000 152

Figure 7088 available in Nominal Pipe Sizes 2" through 4" only.

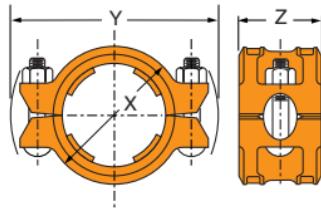
Figure 7089 available in Nominal Pipe Sizes 2" through 6" only.

Figure 7090 available in Nominal Pipe Sizes 3/4" through 2" only.

## Plain-End Fittings

**FIG. 7005**

ROUGHNECK® COUPLING



**NOTES:**

See Coupling data chart notes in technical data section for additional information.

§ – For additional Bolt Torque information see page 202  
see “Coupling Data Chart Notes” on page 264.

Not for use in copper or PVC systems.

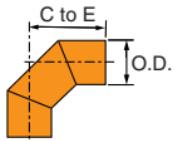
See Installation & Assembly directions on pages 176-177.

**FIGURE 7005 - ROUGHNECK® COUPLING**

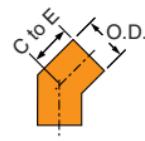
Nominal Size	O.D.	Max. Wk. Pressure	Max. End Load	No. of Grippers	Coupling Dimensions			Coupling Bolts			Specified Torque §		Approx. Wt. Ea.	
					X	Y	Z	Qty.	Size	Min.	Max.	LbFt/N-m	LbFt/N-m	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN		In./mm	In./mm	In./mm		In./mm					Lbs./Kg
2	2.375	750	3,323	8	3 <sup>3</sup> / <sub>4</sub>	6 <sup>5</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>2</sub>	2	5 <sup>5</sup> / <sub>8</sub> x 3 <sup>1</sup> / <sub>4</sub>	150	190	6.6		
50	60.3	51.7	1,507		95	162	89		-	203	257	3.0		
2 <sup>1</sup> / <sub>2</sub>	2.875	600	3,895	8	4 <sup>1</sup> / <sub>4</sub>	7 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>2</sub>	2	5 <sup>5</sup> / <sub>8</sub> x 3 <sup>1</sup> / <sub>4</sub>	150	190	7.4		
65	73.0	41.4	1,766		108	181	89		-	203	257	3.4		
3	3.500	600	5,773	8	4 <sup>7</sup> / <sub>8</sub>	8 <sup>1</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>2</sub>	2	3 <sup>3</sup> / <sub>4</sub> x 4 <sup>1</sup> / <sub>2</sub>	200	250	10.5		
80	88.9	41.4	2,618		124	206	89		-	271	339	4.8		
4	4.500	450	7,157	8	6 <sup>3</sup> / <sub>8</sub>	9 <sup>9</sup> / <sub>16</sub>	4 <sup>1</sup> / <sub>8</sub>	2	3 <sup>3</sup> / <sub>4</sub> x 4 <sup>1</sup> / <sub>2</sub>	200	250	16.4		
100	114.3	31.0	3,246		162	238	105		-	271	339	7.4		
5	5.563	350	8,507	8	7 <sup>1</sup> / <sub>2</sub>	11 <sup>1</sup> / <sub>8</sub>	4 <sup>3</sup> / <sub>8</sub>	2	7 <sup>7</sup> / <sub>8</sub> x 5	250	300	23.8		
125	141.3	24.1	3,858		191	283	111		-	339	406	10.8		
6	6.625	300	10,341	12	8 <sup>3</sup> / <sub>4</sub>	12 <sup>7</sup> / <sub>8</sub>	4 <sup>3</sup> / <sub>8</sub>	2	1 x 6	250	300	31.7		
150	168.3	20.7	4,690		222	327	111		-	339	406	14.4		
8	8.625	300	17,528	12	10 <sup>7</sup> / <sub>8</sub>	14 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>2</sub>	4	7 <sup>7</sup> / <sub>8</sub> x 5	250	300	38.6		
200	219.1	20.7	7,950		276	368	114		-	339	406	17.5		
10	10.750	300	27,229	8	12 <sup>5</sup> / <sub>8</sub>	18	5 <sup>3</sup> / <sub>8</sub>	4	1 x 6 <sup>1</sup> / <sub>2</sub>	500	600	40		
250	273.1	20.7	12,377		321	457	137		-	678	814	18.1		
12	12.750	300	31,919	12	14 <sup>7</sup> / <sub>8</sub>	20 <sup>1</sup> / <sub>4</sub>	5 <sup>3</sup> / <sub>8</sub>	4	1 x 6 <sup>1</sup> / <sub>2</sub>	550	700	56		
300	323.9	20.7	14,509		378	514	137		-	746	949	25.4		
14	14.000	300	30,788	12	16 <sup>3</sup> / <sub>4</sub>	22 <sup>1</sup> / <sub>8</sub>	6 <sup>1</sup> / <sub>4</sub>	4	1 x 6 <sup>1</sup> / <sub>2</sub>	550	700	88		
350	355.6	20.7	13,995		425	562	159		-	746	949	39.9		
16	16.000	300	30,159	12	18 <sup>3</sup> / <sub>4</sub>	24	6 <sup>1</sup> / <sub>4</sub>	4	1 x 6 <sup>1</sup> / <sub>2</sub>	550	700	95		
400	406.4	20.7	13,709		476	610	159		-	746	949	43.1		

**FIG. 7050P**

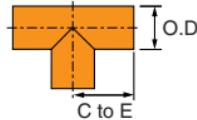
90° ELBOW

**FIG. 7051P**

45° ELBOW

**FIG. 7060P**

TEE

**FIGURE 7050P - 90° ELBOW**

Nominal Size	O.D.	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4 $\frac{1}{4}$	2.7
50	60.3	121	1.2
2 $\frac{1}{2}$	2.875	5 $\frac{1}{2}$	4.8
65	73.0	140	2.2
3	3.500	6 $\frac{1}{4}$	7.2
80	88.9	159	3.3
3 $\frac{1}{2}$	4.000	7	9.4
90	101.6	178	4.3
4	4.500	7 $\frac{3}{4}$	12.3
100	114.3	197	5.6
5	5.563	9 $\frac{1}{2}$	13.4
125	141.3	241	6.1
6	6.625	11	31
150	168.3	279	14.1
8	8.625	11	38.7
200	219.1	279	17.6

**FIGURE 7051P - 45° ELBOW**

Nominal Size	O.D.	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	3 $\frac{1}{8}$	2.0
50	60.3	79	0.9
2 $\frac{1}{2}$	2.875	3 $\frac{1}{8}$	3.5
65	73.0	89	1.6
3	3.500	3 $\frac{3}{4}$	4.8
80	88.9	95	2.2
3 $\frac{1}{2}$	4.000	4	6.2
90	101.6	102	2.8
4	4.500	4 $\frac{1}{4}$	8.0
100	114.3	108	3.6
5	5.563	5 $\frac{1}{8}$	9.2
125	141.3	130	4.2
6	6.625	5 $\frac{3}{4}$	18.5
150	168.3	146	8.4
8	8.625	6	24.9
200	219.1	152	11.3

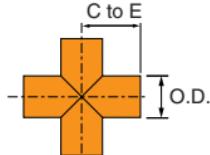
**FIGURE 7060P - TEE**

Nominal Size	O.D.	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4 $\frac{1}{4}$	3.5
50	60.3	108	1.6
2 $\frac{1}{2}$	2.875	4 $\frac{3}{4}$	6.2
65	73.0	121	2.8
3	3.500	5 $\frac{1}{8}$	8.6
80	88.9	130	3.9
3 $\frac{1}{2}$	4.000	5 $\frac{1}{2}$	11
90	101.6	140	5.0
4	4.500	5 $\frac{7}{8}$	13.8
100	114.3	149	6.3
5	5.563	6 $\frac{7}{8}$	21.7
125	141.3	175	9.8
6	6.625	7 $\frac{5}{8}$	30.9
150	168.3	194	14.0
8	8.625	10	61.1
200	219.1	254	27.7

## Plain-End Fittings

**FIG. 7068P**

CROSS

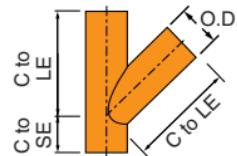


**FIGURE 7068P - CROSS**

Nominal Size	O.D.	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4 $\frac{1}{4}$	4.4
50	60.3	108	2.0
2 $\frac{1}{2}$	2.875	4 $\frac{3}{4}$	7.8
65	73.0	121	3.5
3	3.500	5 $\frac{1}{8}$	10.7
80	88.9	130	4.9
3 $\frac{1}{2}$	4.000	5 $\frac{1}{2}$	13.7
90	101.6	140	6.2
4	4.500	5 $\frac{7}{8}$	17
100	114.3	149	7.7
5	5.563	6 $\frac{1}{8}$	26.7
125	141.3	175	12.1
6	6.625	7 $\frac{5}{8}$	37.7
150	168.3	194	17.1
8	8.625	10	74.6
200	219.1	254	33.8

**FIG. 7069P**

45° LATERAL

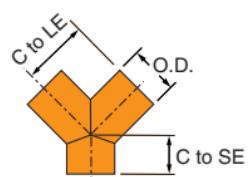


**FIGURE 7069P - 45° LATERAL**

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
2	2.375	7 $\frac{1}{4}$	2 $\frac{3}{4}$	5.1
50	60.3	184	70	2.3
2 $\frac{1}{2}$	2.875	7 $\frac{3}{4}$	3	9.5
65	73.0	197	76	4.3
3	3.500	8 $\frac{3}{4}$	3 $\frac{1}{4}$	12.8
80	88.9	222	83	5.8
3 $\frac{1}{2}$	4.000	10	3 $\frac{1}{2}$	20.0
90	101.6	254	89	9.1
4	4.500	10 $\frac{3}{4}$	3 $\frac{3}{4}$	22.2
100	114.3	273	95	10.1
5	5.563	12 $\frac{3}{4}$	4	38.0
125	141.3	324	102	17.2
6	6.625	14	4 $\frac{1}{2}$	54.0
150	168.3	356	114	24.5
8	8.625	18	6	92.0
200	219.1	457	152	41.7

**FIG. 7071P**

90° TRUE WYE



**FIGURE 7071P - 90° TRUE WYE**

Nominal Size	O.D.	Center to Long End	Center to Short End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	In./mm	Lbs./Kg
2	2.375	4 $\frac{1}{4}$	2 $\frac{3}{4}$	3.5
50	60.3	108	70	1.6
2 $\frac{1}{2}$	2.875	4 $\frac{3}{4}$	3	6.2
65	73.0	121	76	2.8
3	3.500	5 $\frac{1}{8}$	3 $\frac{1}{4}$	8.5
80	88.9	130	83	3.9
3 $\frac{1}{2}$	4.000	5 $\frac{1}{2}$	3 $\frac{1}{2}$	10.0
90	101.6	140	89	4.5
4	4.500	5 $\frac{7}{8}$	3 $\frac{3}{4}$	14.0
100	114.3	149	95	6.4
5	5.563	6 $\frac{1}{8}$	4	21.6
125	141.3	175	102	9.8
6	6.625	7 $\frac{5}{8}$	4 $\frac{1}{2}$	31.2
150	168.3	194	114	14.2
8	8.625	10	6	53.6
200	219.1	254	152	24.3

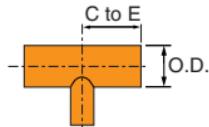
**FIG. 7061P**

REDUCING TEE

**FIGURE 7061P - REDUCING TEE**

Nominal Size	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
3 x 3 x 2 80 x 80 x 50	5½ 140	7.1 3.2
4 x 4 x 2 100 x 100 x 50	5½ 149	11.3 5.1
4 x 4 x 2½ 100 x 100 x 65	5½ 149	11.6 5.3
4 x 4 x 3 100 x 100 x 80	5½ 149	11.9 5.4
6 x 6 x 2 150 x 150 x 50	7½ 194	24.6 11.2
6 x 6 x 3 150 x 150 x 80	7½ 194	25.4 11.5
6 x 6 x 4 150 x 150 x 100	7½ 194	26.2 11.9
8 x 8 x 2 200 x 200 x 50	10 254	42.0 19.1
8 x 8 x 3 200 x 200 x 80	10 254	44.0 20.0

Nominal Size	Center To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
8 x 8 x 4 200 x 200 x 100	10 254	46.0 20.9
8 x 8 x 5 200 x 200 x 125	10 2254	48.0 21.8
8 x 8 x 6 200 x 200 x 150	10 254	50.0 22.7
10 x 10 x 4 250 x 250 x 100	11½ 292	74.0 33.6
10 x 10 x 6 250 x 250 x 150	11½ 292	78.0 35.4
10 x 10 x 8 250 x 250 x 200	11½ 292	86.0 39.0
12 x 12 x 6 300 x 300 x 150	13½ 343	112.0 50.8
12 x 12 x 8 300 x 300 x 200	13½ 343	118.0 53.5
12 x 12 x 10 300 x 300 x 250	13½ 343	130.0 59.0

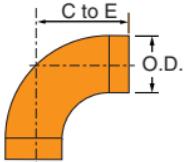


See Fitting Size Chart on page 148 for O.D. sizes

## Plain-End Fittings

**FIG. 7050LRP**

90° LR ELBOW



**FIGURE 7050 LRP - 90° LR ELBOW**

Nominal Size In./DN(mm)	O.D. In./mm	Center To End In./mm	Approx. Wt. Ea. Lbs./Kg
2	2.375	5	2.5
50	60.3	127	1.1
2½	2.875	5¾	4.9
65	73.0	146	22
3	3.500	6½	6.5
80	88.9	165	2.9
3½	4.000	7¼	9.8
90	101.6	184	4.4
4	4.500	8	11.5
100	114.3	203	5.2
5	5.563	9¾	21.5
125	141.3	248	9.8
6	6.625	11¼	28.5
150	168.3	286	12.9
8	8.625	15	56.7
200	219.1	381	25.7

**FIG. 7051LRP**

45° LR ELBOW

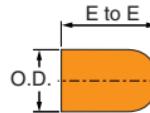


**FIGURE 7051 LRP - 45° LR ELBOW**

Nominal Size In./DN(mm)	O.D. In./mm	Center To End In./mm	Approx. Wt. Ea. Lbs./Kg
2	2.375	3⅜	1.8
50	60.3	86	0.8
2½	2.875	3¾	3.6
65	73.0	95	1.6
3	3.500	4	4.5
80	88.9	102	2.0
3½	4.000	4¼	6.7
90	101.6	108	3.0
4	4.500	4½	7.5
100	114.3	114	3.4
5	5.563	5¾	13.8
125	141.3	137	6.3
6	6.625	6	17.3
150	168.3	152	7.8
8	8.625	8	34.0
200	219.1	203	15.4

**FIG. 7075P**

BULL PLUG

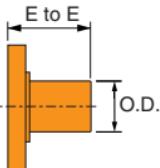


**FIGURE 7075P - BULL PLUG**

Nominal Size In./DN(mm)	O.D. In./mm	Center To End In./mm	Approx. Wt. Ea. Lbs./Kg
2	2.375	4	2.3
50	60.3	102	1.0
2½	2.875	5	3.0
65	73.0	127	1.4
3	3.500	6	4.5
80	88.9	152	2.0
3½	4.000	6½	5.5
90	101.6	165	2.5
4	4.500	7	7.5
100	114.3	178	3.4
5	5.563	8½	12.5
125	141.3	216	5.7
6	6.625	10	17.0
150	168.3	254	7.7
8	8.625	11	29.0
200	219.1	279	13.2

**FIG. 7084P & FIG. 7085P**

FLANGE NIPPLES  
(Plain-End x Class 150 or 300)

**FIGURE 7084P - PLAIN-END X CLASS 150 FLANGE NIPPLES**

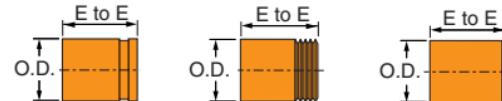
Nominal Size	O.D.	End To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4	6.0
50	60.3	102	2.7
2½	2.875	4	9.2
65	73.0	102	4.2
3	3.500	4	10.4
80	88.9	102	4.7
3½	4.000	4	14.0
90	101.6	102	6.4
4	4.500	6	19.1
100	114.3	152	8.7
5	5.563	6	23.0
125	141.3	152	10.4
6	6.625	6	29.5
150	168.3	152	13.4
8	8.625	6	43.5
200	219.1	152	19.7

**FIGURE 7085P - PLAIN-END X CLASS 300 FLANGE NIPPLES**

End To End	Approx. Wt. Ea.
In./mm	Lbs./Kg
4	8.2
102	3.7
4	11.9
102	5.4
4	15.5
102	7.0
4	21.0
102	9.5
6	28.0
152	12.7
6	35.0
152	15.9
6	50.0
152	22.7
6	72.0
152	32.7

**FIG. 7080P, FIG. 7081P & FIG. 7082P**

ADAPTER NIPPLES

**FIG. 7080P**

Plain x Grooved

**FIG. 7081P**

Plain x Thread

**FIG. 7082P**

Plain x Bevel

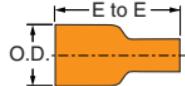
**FIGURE 7080P, 7081P, 7082P - ADAPTER NIPPLES**

Nominal Size	O.D.	End To End	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
2	2.375	4	1.2
50	60.3	102	0.5
2½	2.875	4	1.9
65	73.0	102	0.9
3	3.500	4	2.5
80	88.9	102	1.1
3½	4.000	4	3.1
90	101.6	102	1.4
4	4.500	6	5.5
100	114.3	152	2.5
5	5.563	6	7.4
125	141.3	152	3.4
6	6.625	6	9.5
150	168.3	152	4.3
8	8.625	6	14.2
200	219.1	152	6.4

## Plain-End Fittings

**FIG. 7077P**

SWAGED NIPPLES



**FIGURE 7077P - SWAGED NIPPLES**

Nominal Size <i>In./DN(mm)</i>	End Center To End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
2½ x 2 65 x 50	7 178	3.0 1.4
3 x 2 80 x 50	8 203	4.5 2.0
3 x 2½ 80 x 65	8 203	4.5 2.0
4 x 2 100 x 50	9 229	7.5 3.4
4 x 2½ 100 x 65	9 229	7.5 3.4
4 x 3 100 x 80	9 229	7.5 3.4
5 x 2 125 x 50	11 279	11.5 5.2
5 x 3 125 x 80	11 279	11.5 5.2
5 x 4 125 x 100	11 279	11.5 5.2

See Fitting Size Chart on page 148 for O.D. sizes

Nominal Size <i>In./DN(mm)</i>	End Center To End <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
6 x 2 150 x 50	12 305	17.0 7.7
6 x 2½ 150 x 65	12 305	17.0 7.7
6 x 3 150 x 80	12 305	17.0 7.7
6 x 4 150 x 100	12 305	17.0 7.7
6 x 5 150 x 125	12 305	17.0 7.7
8 x 3 200 x 80	13 330	29.0 13.2
8 x 4 200 x 100	13 330	29.0 13.2
8 x 5 200 x 125	13 330	29.0 13.2
8 x 6 200 x 150	13 330	29.0 13.2

**FIG. 7305**

HDPE COUPLING

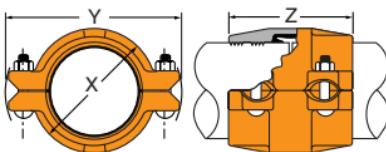


FIGURE 7305 - HDPE COUPLING

Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Coupling Dimensions			Coupling Bolts		Approx. Wt. Ea. <i>Lbs./Kg</i>
		X <i>In./mm</i>	Y <i>In./mm</i>	Z <i>In./mm</i>	Qty.	Size <i>In.</i>	
2 50	2.375 60.3	3 $\frac{3}{8}$ 86	5 $\frac{1}{2}$ 140	4 $\frac{5}{8}$ 117	4	1 $\frac{1}{2}$ x 2 $\frac{3}{8}$	4.5 2.0
3 80	3.500 88.9	4 $\frac{5}{8}$ 117	6 $\frac{3}{4}$ 171	4 $\frac{5}{8}$ 117	4	1 $\frac{1}{2}$ x 3	8.5 3.9
4 100	4.500 114.3	5 $\frac{1}{4}$ 133	8 203	5 $\frac{3}{4}$ 146	4	1 $\frac{1}{2}$ x 3	12 5.4
6 150	6.625 168.3	7 $\frac{1}{2}$ 191	11 279	5 $\frac{7}{8}$ 149	4	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$	18 8.2
8 200	8.625 219.1	10 254	13 $\frac{1}{4}$ 337	6 152	4	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$	30 13.6
10 250	10.750 273.1	12 305	15 $\frac{3}{4}$ 400	6 $\frac{1}{2}$ 165	4	3 $\frac{1}{4}$ x 4 $\frac{3}{4}$	43 19.5
12 300	12.750 323.9	14 $\frac{1}{8}$ 365	17 $\frac{1}{8}$ 454	7 $\frac{1}{4}$ 184	4	3 $\frac{1}{4}$ x 4 $\frac{3}{4}$	58 26.3

See Installation &amp; Assembly directions on pages 178-179.

**FIG. 7307**

HDPE TRANSITION COUPLING

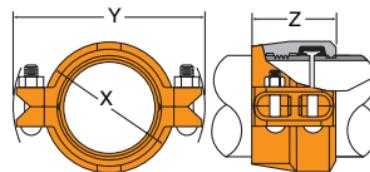


FIGURE 7307 - HDPE TRANSITION COUPLING

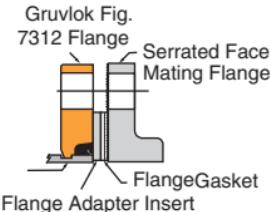
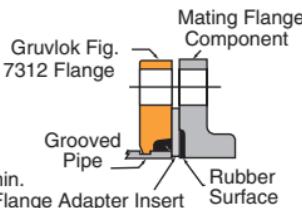
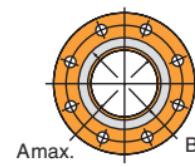
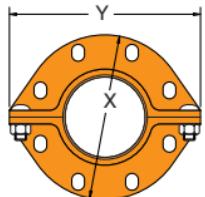
Nominal Size <i>In./DN(mm)</i>	O.D. <i>In./mm</i>	Coupling Dimensions			Coupling Bolts		Approx. Wt. Ea. <i>Lbs./Kg</i>
		X <i>In./mm</i>	Y <i>In./mm</i>	Z <i>In./mm</i>	Qty.	Size <i>In.</i>	
2 50	2.375 60.3	3 $\frac{3}{8}$ 86	6 152	3 $\frac{1}{8}$ 79	4	1 $\frac{1}{2}$ x 2 $\frac{3}{8}$	4.5 2.0
3 80	3.500 88.9	4 $\frac{1}{2}$ 114	7 $\frac{1}{8}$ 181	3 $\frac{1}{8}$ 79	4	1 $\frac{1}{2}$ x 3	6 2.7
4 100	4.500 114.3	5 $\frac{3}{4}$ 146	8 $\frac{1}{2}$ 216	3 $\frac{3}{4}$ 95	4	1 $\frac{1}{2}$ x 3	8.5 3.9
6 150	6.625 168.3	8 203	11 $\frac{1}{4}$ 286	3 $\frac{3}{4}$ 95	4	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$	12.5 5.7
8 200	8.625 219.1	10 $\frac{1}{2}$ 267	13 $\frac{5}{8}$ 346	4 $\frac{1}{4}$ 108	4	5 $\frac{1}{8}$ x 3 $\frac{1}{2}$	20.5 9.3
10 250	10.750 273.1	12 $\frac{5}{8}$ 321	17 432	5 127	4	7 $\frac{1}{8}$ x 5 $\frac{1}{2}$	34.5 15.6
12 300	12.750 323.9	14 $\frac{3}{4}$ 375	19 $\frac{1}{2}$ 495	5 127	4	7 $\frac{1}{8}$ x 5 $\frac{1}{2}$	42.5 19.3

See Installation &amp; Assembly directions on pages 180-181.

## HDPE Couplings

**FIG. 7312**

HDPE FLANGE ADAPTER



**FIGURE 7312 - HDPE FLANGE ADAPTER**

Nominal Size	O.D.	Flange Dimensions			Sealing Surface		Latch Bolt		Mating Flange Bolts		Approx. Wt. Ea.
		X	Y	Z	A Max	B Min.	Qty.	Size	Qty.	Size	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm					Lbs./Kg
4	4.500	9	10 $\frac{1}{8}$	3 $\frac{1}{8}$	4 $\frac{1}{2}$	5 $\frac{3}{4}$	2	$\frac{5}{8} \times 1\frac{1}{8}$	8	$\frac{5}{8} \times 3$	15
100	114.3	229	264	79	114	146					6.8
6	6.625	11 $\frac{1}{4}$	12 $\frac{1}{8}$	3 $\frac{7}{8}$	6 $\frac{1}{8}$	7 $\frac{3}{4}$	2	$\frac{5}{8} \times 1\frac{1}{8}$	8	$\frac{3}{4} \times 3\frac{1}{2}$	22
150	168.3	286	314	98	168	197					10.0
8	8.625	13 $\frac{1}{2}$	14 $\frac{1}{8}$	3 $\frac{1}{2}$	8 $\frac{1}{8}$	10 $\frac{1}{4}$	2	$\frac{3}{4} \times 2$	8	$\frac{3}{4} \times 3\frac{1}{2}$	26
200	219.1	343	378	89	219	260					12.7

- A. The sealing surfaces A Max. to B Min. of the mating flange must be free from gouges, undulations and deformities of any type to ensure proper sealing of gasket.
- B. Gruvlok Flanges are to be assembled on butterfly valves so as not to interfere with actuator or handle operation.
- C. Do not use Gruvlok Flanges within 90 degrees of one another on standard fittings because the outside dimensions may cause interference.
- D. Gruvlok Flanges should not be used as anchor points for tierods across non-restrained joints.

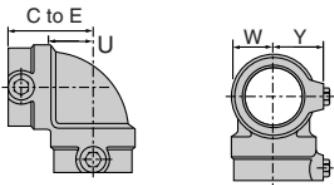
E. Fig. 7012 Gruvlok Flange sealing gaskets require a hard flat surface for adequate sealing. The use of a Gruvlok Flange Adapter Insert is required for applications against rubber faced valves or other equipment. The Gruvlok Flange Adapter Insert is installed between the Gruvlok Flange sealing gasket and the mating flange or surface to provide a good sealing surface area.

F. Gruvlok Flanges are not recommended for use against formed rubber flanges.

See Installation & Assembly directions on pages 182-183.

**FIG. 7100**

90° ELBOW (SOCK-IT® x SOCK-IT®)



See Installation & Assembly directions on pages 184-185.

See Fitting Size Chart on page 148 for O.D. sizes

**FIGURE 7100 - SOCK-IT® ELBOW (S x S)**

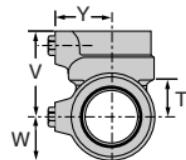
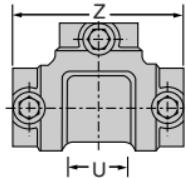
Nominal Size	O.D.	Max. Working Pressure		Dimensions				Approx. Wt. Ea.
		UL/ULC Listed	FM Approved	Center To End	U*	W	Y	
In./DN(mm)	In./mm	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	300	300	2 <sup>5</sup> / <sub>16</sub>	7/8	1 <sup>1</sup> / <sub>16</sub>	1 <sup>3</sup> / <sub>4</sub>	1.9
25	33.7	20.7	20.7	59	22	27	44	0.9
1 <sup>1</sup> / <sub>4</sub>	1.660	300	300	2 <sup>7</sup> / <sub>16</sub>	1	1 <sup>1</sup> / <sub>4</sub>	1 <sup>13</sup> / <sub>16</sub>	2.3
32	42.4	20.7	20.7	62	25	32	46	1.0
1 <sup>1</sup> / <sub>2</sub>	1.900	300	300	2 <sup>5</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>8</sub>	1 <sup>15</sup> / <sub>16</sub>	2.7
40	48.3	20.7	20.7	67	29	35	49	1.2
2	2.375	175	250	3 <sup>1</sup> / <sub>4</sub>	1 <sup>9</sup> / <sub>16</sub>	1 <sup>5</sup> / <sub>8</sub>	2 <sup>3</sup> / <sub>16</sub>	4.0
50	60.3	12.1	17.2	83	40	41	56	1.8

\* "U" - Run take-out dimension.

## Sock-It® Method

**FIG. 7103**

STRAIGHT TEE (SOCK-IT® x SOCK-IT® x SOCK-IT®)

**FIGURE 7103 - SOCK-IT® STRAIGHT TEE (S x S x S)**

Nominal Size	O.D.	Max. Working Pressure		Dimensions						Z	Approx. Wt. Ea.
		UL/ULC Listed	FM Approved	**T	U*	V	W	Y			
In./DN(mm)	In./mm	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	300	300	1 $\frac{3}{16}$	1 $\frac{5}{8}$	2 $\frac{1}{4}$	1 $\frac{1}{16}$	1 $\frac{11}{16}$	4 $\frac{1}{2}$	2.3	
25	33.7	20.7	20.7	30	41	57	27	43	114	1.0	
1 $\frac{1}{4}$	1.660	175	300	1	2	2 $\frac{7}{16}$	1 $\frac{1}{4}$	1 $\frac{13}{16}$	4 $\frac{7}{8}$	2.9	
32	42.4	12.1	20.7	25	51	62	32	46	124	1.3	
1 $\frac{1}{2}$	1.900	175	300	1 $\frac{1}{16}$	2 $\frac{1}{8}$	2 $\frac{9}{16}$	1 $\frac{3}{8}$	1 $\frac{15}{16}$	5 $\frac{1}{8}$	3.4	
40	48.3	12.1	20.7	27	54	65	35	49	130	1.5	
2	2.375	175	250	1 $\frac{5}{16}$	2 $\frac{5}{8}$	3	1 $\frac{11}{16}$	2 $\frac{3}{16}$	6	5.6	
50	60.3	12.1	17.2	33	67	76	43	56	152	2.5	

\* "U" - Run take-out dimension.

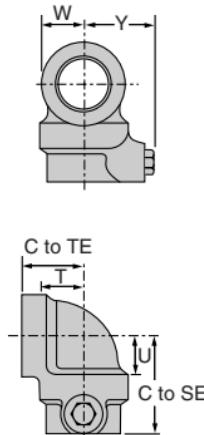
\*\*"T" - Outlet take-out dimension.

See Installation & Assembly directions on  
pages 184-185.

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7101**

90° REDUCING ELBOW (SOCK-IT® x NPT)



See Installation & Assembly  
directions on pages 184-185.

See Fitting Size Chart on page 148  
for O.D. sizes

**FIGURE 7101 - SOCK-IT® REDUCING ELBOW (S x NPT)**

Nominal Size	Max. Working Pressure		Dimensions							Approx. Wt. Ea.
	UL/ULC Listed	FM Approved	Center to TE	Center To SE	U*	T**	W	Y		
In./DN(mm)	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg	
1 x 1½	300	300	1⅞	2⅝	⅛	1	1⅓	1⅛	1.7	
25 x 15	20.7	20.7	37	59	22	25	27	43	0.8	
1 x ¾	300	300	1⅞	2⅝	⅛	⅜	1⅓	1⅛	1.6	
25 x 20	20.7	20.7	37	59	22	22	27	43	0.7	
1 x 1	300	300	1⅞	2⅝	⅛	⅜	1⅓	1⅛	1.5	
25 x 25	20.7	20.7	37	59	22	22	27	43	0.7	
1¼ x ½	300	300	1⅙	2½	1⅛	⅓	1¼	1⅛	2.2	
32 x 15	20.7	20.7	40	64	27	29	32	46	1.0	
1¼ x ¾	300	300	1⅙	2½	1⅛	1	1¼	1⅛	2.1	
32 x 20	20.7	20.7	40	64	27	25	32	46	1.0	
1¼ x 1	300	300	1⅙	2½	1⅛	1	1¼	1⅛	2	
32 x 25	20.7	20.7	40	64	27	25	32	46	0.9	
1½ x ½	300	300	1⅛	2½	1	⅓	1¾	1⅛	2.5	
40 x 15	20.7	20.7	43	64	25	32	35	49	1.1	
1½ x ¾	300	300	1⅛	2½	1	⅓	1¾	1⅛	2.4	
40 x 20	20.7	20.7	43	64	25	29	35	49	1.1	
1½ x 1	300	300	1⅛	2½	1	⅓	1¾	1⅛	2.3	
40 x 25	20.7	20.7	43	64	25	29	35	49	1.0	

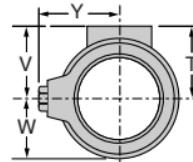
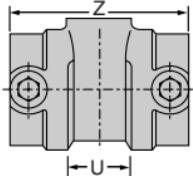
\* "U" - Take-out dimension, Sock-It® End.

\*\* "T" - Take-out dimension, Thread End.

## Sock-It® Method

FIG. 7105

REDUCING OUTLET TEE  
(SOCK-IT® x SOCK-IT® x NPT)



Note: Anvil® is the only manufacturer to offer a 2½" Sock-It Fitting

\* "U" - Run take-out dimension.

\*\* "T" - Outlet take-out dimension.

See Installation & Assembly directions on pages 184-185.

See Fitting Size Chart on page 148 for O.D. sizes

FIGURE 7105 - SOCK-IT® REDUCING OUTLET TEE (S x S x NPT)

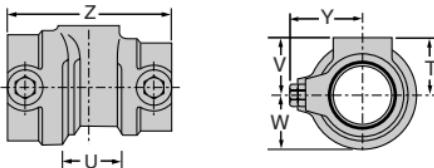
Nominal Size	Max. Working Pressure		Dimensions						Approx. Wt. Ea.
	UL/ULC Listed	FM Approved	**T	U*	V	W	Y	Z	
In./DN(mm)	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
1 x 1 x 1½	300	300	1	1⅓	1⅞	1⅓	1⅛	4⅓	2.0
25 x 25 x 15	20.7	20.7	25	35	37	27	43	108	0.9
1 x 1 x ¾	300	300	⅜	1⅓	1⅞	1⅓	1⅛	4⅓	1.9
25 x 25 x 20	20.7	20.7	22	35	37	27	43	108	0.9
1 x 1 x 1	300	300	⅜	1⅓	1⅞	1⅓	1⅛	4⅓	1.9
25 x 25 x 25	20.7	20.7	22	35	37	27	43	108	0.9
1¼ x 1¼ x 1½	300	300	1⅛	1⅓	1⅛	1¼	1⅓	4⅓	2.2
32 x 32 x 15	20.7	20.7	29	35	41	32	46	108	1.0
1¼ x 1¼ x ¾	300	300	1	1⅓	1⅛	1¼	1⅓	4⅓	2.2
32 x 32 x 20	20.7	20.7	25	35	41	32	46	108	1.0
1¼ x 1¼ x 1	300	300	1	1⅓	1⅛	1¼	1⅓	4⅓	2.0
32 x 32 x 25	20.7	20.7	25	35	41	32	46	108	0.9
1½ x 1½ x ½	300	300	1½	1⅓	1¾	1¾	1⅓	4¾	2.7
40 x 40 x 15	20.7	20.7	32	35	44	35	49	111	1.2
1½ x 1½ x ¾	300	300	1½	1⅓	1¾	1¾	1⅓	4¾	2.6
40 x 40 x 20	20.7	20.7	29	35	44	35	49	111	1.2
1½ x 1½ x 1	300	300	1½	1⅓	1¾	1¾	1⅓	4¾	2.5
40 x 40 x 25	20.7	20.7	29	35	44	35	49	111	1.1
2 x 2 x ½	175	250	1½	1⅓	1⅞	1¾	2⅓	4¾	3.5
50 x 50 x 15	12.1	17.2	38	35	49	41	56	121	1.6
2 x 2 x ¾	175	250	1½	1⅓	1⅞	1¾	2⅓	4¾	3.4
50 x 50 x 20	12.1	17.2	35	35	49	41	56	121	1.5
2 x 2 x 1	175	250	1½	1⅓	1⅞	1¾	2⅓	4¾	3.3
50 x 50 x 25	12.1	17.2	35	35	49	41	56	121	1.5
2½ x 2½ x ¾	175	175	1½	1⅓	2⅛	1⅓	2⅓	4¾	5.2
65 x 65 x 20	12.1	12.1	38	35	54	49	62	121	2.4
2½ x 2½ x 1	175	175	1½	1⅓	2⅛	1⅓	2⅓	4¾	5.2
65 x 65 x 25	12.1	12.1	38	35	54	49	62	121	2.4

For Gruvlok Technical Detail Refer to the Gruvlok Catalog or contact your local Anvil sales representative.

[www.anvilintl.com](http://www.anvilintl.com)

**FIG. 7106**

**REDUCING TEE**  
(SOCK-IT® x SOCK-IT® x NPT)

**FIGURE 7106 - SOCK-IT® REDUCING TEE (S x S x NPT)**

Nominal Size	Max. Working Pressure		Dimensions						Approx. Wt. Ea.
	UL/ULC Listed	FM Approved	**T	U*	V	W	Y	Z	
In./DN(mm)	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
1 1/4 x 1 x 1 1/2 32 x 25 x 15	300 2.1	300 2.1	1 25	1 3/8 35	1 1/16 37	1 1/4 32	1 13/16 46	4 1/4 108	2.1 1.0
1 1/4 x 1 x 3/4 32 x 25 x 20	300 20.7	300 20.7	7/8 22	1 3/8 35	1 1/16 37	1 1/4 32	1 13/16 46	4 1/4 108	2.1 1.0
1 1/4 x 1 x 1 32 x 25 x 25	300 20.7	300 20.7	7/8 22	1 3/8 35	1 1/16 37	1 1/4 32	1 13/16 46	4 1/4 108	2.0 0.9
1 1/2 x 1 1/4 x 1 1/2 40 x 32 x 15	300 20.7	300 20.7	1 1/8 29	1 3/8 35	1 1/16 40	1 3/8 35	1 15/16 49	4 3/8 111	2.5 1.1
1 1/2 x 1 1/4 x 3/4 40 x 32 x 20	300 20.7	300 20.7	1 25	1 3/8 35	1 1/16 40	1 3/8 35	1 15/16 49	4 3/8 111	2.4 1.1
1 1/2 x 1 1/4 x 1 40 x 32 x 25	300 20.7	300 20.7	1 25	1 3/8 35	1 1/16 40	1 3/8 35	1 15/16 49	4 3/8 111	2.2 1.0
2 x 1 1/2 x 1 1/2 50 x 40 x 15	175 12.1	250 17.2	1 1/4 32	1 3/8 35	1 3/4 44	1 5/8 41	2 3/16 56	4 9/16 116	3.2 1.5
2 x 1 1/2 x 3/4 50 x 40 x 20	175 12.1	250 17.2	1 1/8 29	1 3/8 35	1 1/4 44	1 5/8 41	2 3/16 56	4 9/16 116	3.1 1.4
2 x 1 1/2 x 1 50 x 40 x 25	175 12.1	250 17.2	1 1/8 29	1 3/8 35	1 3/4 44	1 5/8 41	2 3/16 56	4 9/16 116	3.0 1.4

\* "U" - Run take-out dimension.

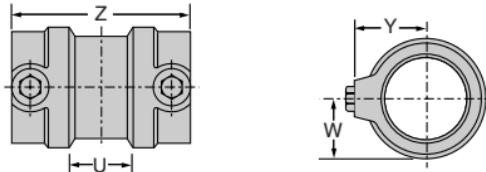
\*\* "T" - Outlet take-out dimension.

See Installation & Assembly directions on pages 184-185.

See Fitting Size Chart on page 148 for O.D. sizes

**Sock-It® Method****FIG. 7107**

COUPLING  
(SOCK-IT® x SOCK-IT®)

**FIGURE 7107 - SOCK-IT® COUPLING (S x S)**

Nominal Size	O.D.	Max. Working Pressure		Dimensions				Approx. Wt. Ea.
		UL/ULC Listed	FM Approved	U*	W	Y	Z	
In./DN(mm)	In./mm	PSI/bar	PSI/bar	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
1	1.315	300	300	1/4	1 1/16	1 1/16	3 1/8	1.7
25	33.7	20.7	20.7	6	27	43	79	0.8
1 1/4	1.660	300	300	1/4	1 1/4	1 3/16	3 1/8	1.9
32	42.4	20.7	20.7	6	32	46	79	0.9
1 1/2	1.900	300	300	1/4	1 5/16	1 5/16	3 1/4	2.1
40	48.3	20.7	20.7	6	35	49	83	1.0
2	2.375	175	250	1/4	1 5/16	2 9/16	3 5/8	2.9
50	60.3	12.1	17.2	6	41	56	92	1.3

\* "U" - Run take-out dimension.

See Installation & Assembly directions on pages 184-185.

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7400SS**

RIGIDLITE® COUPLING

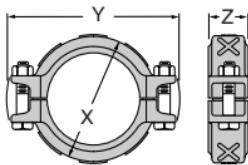


FIGURE 7400SS - RIGIDLITE STAINLESS STEEL COUPLING

Nominal Size	O.D.	Max. Wk. Pressure†	Max. End Load†	Range of Pipe End Separation	Coupling Dimensions			Coupling Bolts* Size (2 required)	Specified Torque		Approx. Wt. Ea.
					X	Y	Z		Min.	Max.	
In./mm	In./mm	PSI/bar	Lbs./kN	In./mm	In./mm	In./mm	In./mm	Ft.-Lbs/N-M		Lbs./Kg	
1 1/4 32	1.66 42.4	300 20.7	649 2.89	0-1/8 0-3.2	2 1/8 73	4 1/8 105	1 3/4 44	5/8 x 2 1/4	15	20	1.6 0.7
1 1/2 40	1.900 48.3	300 20.7	851 3.78	0-1/8 0-3.2	3 1/8 79	4 5/8 117	1 3/4 44	5/8 x 2 1/4	15	20	1.7 0.8
2 50	2.375 60.3	300 20.7	1,329 5.91	0-1/8 0-3.2	3 5/8 92	5 3/8 137	1 3/4 45	5/8 x 2 1/4	15	20	2.1 1.0
2 1/2 65	2.875 73.0	300 20.7	1,785 7.44	0-1/8 0-3.2	4 1/8 105	5 7/8 149	1 3/4 44	5/8 x 2 1/4	15	20	2.3 1.0
3 80	3.500 88.9	300 20.7	2,886 12.84	0-1/8 0-3.2	4 5/8 117	6 5/8 168	1 3/4 44	1/2 x 2 3/4	50	60	3.1 1.4
4 100	4.500 114.3	300 20.7	4,771 21.22	0-1/4 0-6.4	6 152	7 3/4 197	1 1/8 48	1/2 x 2 3/4	50	60	4.4 2.0
6 150	6.625 168.3	275 19.0	9,480 42.17	0-1/4 0-6.4	8 1/8 206	11 1/8 283	2 51	1/2 x 3	80	100	7.8 3.5
8 200	8.625 219.1	275 19.0	16,067 71.47	0-1/4 0-6.4	10 3/8 264	13 3/8 346	2 5/8 60	1/2 x 3	80	100	13.2 6.0

\* All bolts are hex head design Type 316 Grade B8M Class 2 stainless steel to ASTM A193, with Type 316 Grade 8M stainless steel heavy hex nuts conforming to ASTM A194.

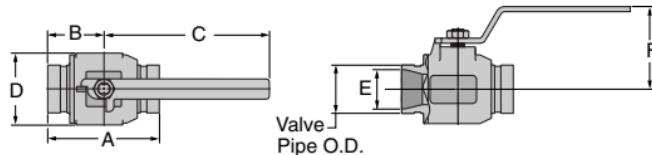
† Ratings apply when used with Schedule 40 ASTM A312 Type 304 stainless steel pipe for all sizes. Refer to ratings chart for additional data.

**CAUTION:** Contact your local Anvil Representative for corrosive application environments.

No Coatings or zinc options.

**Stainless Steel****SERIES 7500 SS**

GROOVED-END BALL VALVE

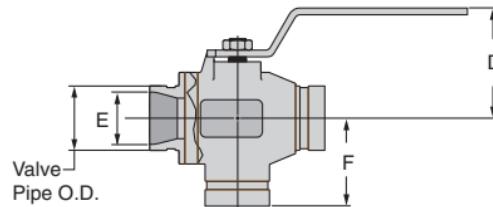
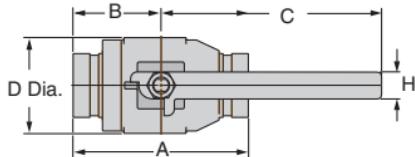
**SERIES 7500 SS - BALL VALVE**

Size ANSI	O.D.	Dimensions							Approx. Wt. Ea.
		A	B	C	D	E	F	Cv	
In./DN(mm)	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	In./mm	Lbs./Kg
2	2.375	5½	2¾	8¼	3¹³/₁₆	1¹⁵/₁₆	4⅛	165	8
50	60.3	140	70	209	81	49	105		3.6
3	3.500	6¾	3¾	10	4¹³/₁₆	2⅓	4¹³/₁₆	310	18
80	88.9	171	85	254	122	74	121		8.2
4	4.500	8¼	4⅛	16	6⁹/₁₆	3¹³/₁₆	6	815	38
100	114.3	210	105	406	176	97	152		17.2
6 *	6.625	10¹/₈	5¹/₁₆	28	8¹/₁₆	5¹¹/₁₆	7⁷/₈	1500	106
150	168.3	257	128	711	215	144	194		48.1

\* Bare Stem

**SERIES 7500 SS**

GROOVED-END BALL VALVE

**SERIES 7500 SS - THREE-WAY DIVERTER VALVES**

Size ANSI	O.D. In./DN	Dimensions							Approx. Wt. Ea. Lb./Kg
		A In./mm	B In./mm	C In./mm	D In./mm	E In./mm	F In./mm	Cv	
2 RP	2.375 RP	6½	3¼	8¼	4⅝	1½	3¼	36	9.0
50	60.3	165	83	209	105	38	83		19.80
2 FP	2.375 FP	6½	3¼	10¾	5¾	2	3¼	135	14.2
50	60.3	165	83	264	137	51	83		31.2

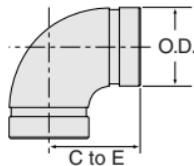
**NOTE:** Contact your Anvil Representative for actuator mounting details.

Full port only.

## Stainless Steel

**FIG. 7050SS**

90° STAINLESS STEEL ELBOW



**NOTE:**

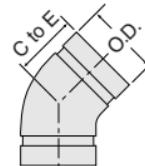
- 1) \* Dimensions may differ from those shown above. Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

**FIG. 7050SS**  
90° STAINLESS STEEL ELBOW

Nominal Size	Center to End *	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
1¼	2 <sup>13</sup> / <sub>16</sub>	0.8
32	71.4	0.4
1½	3	1.0
40	76.2	0.5
2	3 <sup>11</sup> / <sub>16</sub>	1.3
50	93.7	0.6
2½	4 <sup>9</sup> / <sub>16</sub>	1.8
65	109.5	0.8
3	5 <sup>1</sup> / <sub>16</sub>	2.9
80	128.6	1.3
4	6 <sup>9</sup> / <sub>16</sub>	4.6
100	160.3	2.1
5	7 <sup>1</sup> / <sub>2</sub>	8.3
125	190.5	3.7
6	9	11.2
150	228.6	5.1
8	12	22.7
200	304.8	10.3
10	15	35.3
250	381.0	16.0
12	18	56.9
300	457.2	25.8

**FIG. 7051SS**

45° STAINLESS STEEL ELBOW



**NOTE:**

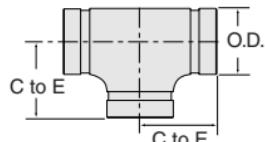
- 1) \* Dimensions may differ from those shown above. Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

**FIG. 7051SS**  
45° STAINLESS STEEL ELBOW

Nominal Size	Center to End *	Approx. Wt. Ea.
In./DN(mm)	In./mm	Lbs./Kg
1¼	1 <sup>3</sup> / <sub>4</sub>	0.4
32	44.5	0.2
1½	1 <sup>7</sup> / <sub>8</sub>	0.5
40	47.6	0.2
2	2 <sup>1</sup> / <sub>8</sub>	0.7
50	54.0	0.3
2½	2 <sup>3</sup> / <sub>8</sub>	0.9
65	60.3	0.4
3	2 <sup>13</sup> / <sub>16</sub>	1.5
80	71.4	0.7
4	3 <sup>5</sup> / <sub>16</sub>	2.4
100	84.1	1.1
5	3 <sup>7</sup> / <sub>8</sub>	4.4
125	98.4	2.0
6	4 <sup>1</sup> / <sub>2</sub>	6.0
150	114.3	2.7
8	5 <sup>7</sup> / <sub>8</sub>	11.7
200	149.2	5.3
10	7 <sup>1</sup> / <sub>8</sub>	17.6
250	181.0	8.0
12	8 <sup>5</sup> / <sub>8</sub>	27.6
300	219.1	12.5

**FIG. 7060SS**

STAINLESS STEEL TEES

**NOTE:**

- 1) \* Dimensions may differ from those shown above. Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

**FIG. 7060SS**  
STAINLESS STEEL TEE

Nominal Size <i>In./DN(mm)</i>	Center to End * <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1/4 32	2 3/4 69.9	1.1 0.5
1 1/2 40	2 15/16 74.6	1.3 0.6
2 50	3 3/16 81.0	3.2 1.5
2 1/2 65	3 11/16 93.7	4.4 2.0
3 80	4 101.6	5.8 2.6
4 100	4 15/16 125.4	8.6 3.9
5 125	5 3/4 146.1	14.5 6.6
6 150	6 1/2 165.1	18.5 8.4
8 200	8 1/16 204.8	33.4 15.1
10 250	9 1/2 241.3	35.3 16.0
12 300	11 279.4	52.7 23.9

**FIG. 7074SS**

STAINLESS STEEL CAPS

**NOTE:**

- 1) \* Dimensions may differ from those shown above. Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

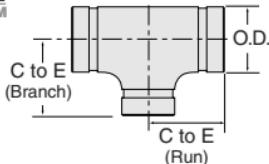
**FIG. 7074SS**  
STAINLESS STEEL CAPS

Nominal Size <i>In./DN(mm)</i>	End to End * <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1/4 32	1 3/4 44.5	0.4 0.2
1 1/2 40	1 3/4 44.5	0.4 0.2
2 50	2 50.8	0.4 0.2
2 1/2 65	2 3/16 55.6	0.9 0.4
3 80	2 9/16 65.1	1.1 0.5
4 100	2 15/16 74.6	1.5 0.7
5 125	3 1/8 79.4	2.5 1.1
6 150	3 9/16 90.5	3.1 1.4
8 200	4 101.6	6.6 3.0
10 250	5 127.0	9.9 4.5
12 300	6 152.4	15.2 6.9

## Stainless Steel

**FIG. 7061SS**

STAINLESS STEEL REDUCING TEES



**NOTE:**

- 1) \* Dimensions may differ from those shown above.  
Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

**FIG. 7061SS - STAINLESS STEEL REDUCING TEE**

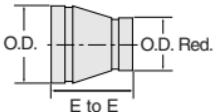
Nominal Size	Center to End (Run) *	Center to End (Branch) *	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
1½ x 1¼	2 <sup>5</sup> / <sub>16</sub>	2 <sup>3</sup> / <sub>4</sub>	1.3
40 x 32	74.6	69.9	0.6
2 x 1¼	3 <sup>3</sup> / <sub>16</sub>	2 <sup>5</sup> / <sub>16</sub>	1.8
50 x 32	81.0	74.6	0.8
2 x 1½	3 <sup>3</sup> / <sub>16</sub>	3 <sup>1</sup> / <sub>16</sub>	1.8
50 x 40	81.0	77.8	0.8
2½ x 1½	3 <sup>1</sup> / <sub>16</sub>	3 <sup>5</sup> / <sub>16</sub>	2.7
65 x 40	93.7	84.1	1.2
2½ x 2	3 <sup>1</sup> / <sub>16</sub>	3 <sup>3</sup> / <sub>16</sub>	2.7
65 x 50	93.7	90.5	1.2
3 x 1½	4	3 <sup>3</sup> / <sub>16</sub>	3.1
80 x 40	101.6	90.5	1.4
3 x 2	4	3 <sup>1</sup> / <sub>16</sub>	5.1
80 x 50	101.6	93.7	2.3
3 x 2½	4	3 <sup>7</sup> / <sub>16</sub>	5.4
80 x 65	101.6	98.4	2.4
4 x 2	4 <sup>5</sup> / <sub>16</sub>	4 <sup>5</sup> / <sub>16</sub>	8.0
100 x 50	125.4	109.5	3.6
4 x 2½	4 <sup>5</sup> / <sub>16</sub>	4 <sup>5</sup> / <sub>16</sub>	5.3
100 x 65	125.4	117.5	2.4

Nominal Size	Center to End (Run) *	Center to End (Branch) *	Approx. Wt. Ea.
In./DN(mm)	In./mm	In./mm	Lbs./Kg
4 x 3	4 <sup>15</sup> / <sub>16</sub>	4 <sup>3</sup> / <sub>4</sub>	8.6
100 x 80	125.4	120.7	3.9
6 x 3	6 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>16</sub>	16.8
150 x 80	165.1	147.6	7.6
6 x 4	6 <sup>1</sup> / <sub>8</sub>	6	16.8
150 x 100	155.6	152.4	7.6
8 x 4	8 <sup>1</sup> / <sub>16</sub>	7 <sup>3</sup> / <sub>16</sub>	29.7
200 x 100	204.8	182.7	13.4
8 x 6	8 <sup>1</sup> / <sub>16</sub>	7 <sup>1</sup> / <sub>16</sub>	33.4
200 x 150	204.8	195.3	15.1
10 x 6	9 <sup>1</sup> / <sub>2</sub>	8 <sup>7</sup> / <sub>16</sub>	21.6
250 x 150	241.3	225.4	9.8
10 x 8	9 <sup>1</sup> / <sub>2</sub>	9 <sup>1</sup> / <sub>16</sub>	32.2
250 x 200	241.3	230.2	14.6
12 x 8	11	10 <sup>1</sup> / <sub>16</sub>	47.2
300 x 200	279.4	255.6	21.4
12 x 10	11	10 <sup>9</sup> / <sub>16</sub>	49.2
300 x 250	279.4	268.3	22.3

See Fitting Size Chart on page 148 for O.D. sizes

**FIG. 7072SS**

STAINLESS STEEL CONCENTRIC REDUCERS

**NOTE:**

- 1) \* Dimensions may differ from those shown above. Contact a Anvil Representative for more information.
- 2) Series 304 SS pressure and load ratings are equal to or greater than pipe Schedule 10S values, refer to the Working Pressure Ratings Chart for Stainless Steel Roll Grooved Pipe on page 3 in the Stainless Steel Brochure.

**FIGURE 7072SS - STAINLESS STEEL CONCENTRIC REDUCERS**

Nominal Size <i>In./DN(mm)</i>	End to End * <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>	Nominal Size <i>In./DN(mm)</i>	End to End * <i>In./mm</i>	Approx. Wt. Ea. <i>Lbs./Kg</i>
1½ x 1¼	3¾	0.4	4 x 3	5½	2.0
40 x 32	95.3	0.2	100 x 80	134.9	0.9
2 x 1¼	4⅛	0.7	6 x 3	6¾	3.8
50 x 32	104.8	0.3	150 x 80	171.5	1.7
2 x 1½	4⅛	0.7	6 x 4	6¾	4.0
50 x 40	104.8	0.3	150 x 100	171.5	1.8
2½ x 1½	4⅞	1.1	8 x 4	7⅓	6.6
65 x 40	112.7	0.5	200 x 100	192.1	3.0
2½ x 2	4⅞	1.1	8 x 6	7⅓	7.3
65 x 50	112.7	0.5	200 x 150	192.1	3.3
3 x 1½	4¾	1.3	10 x 6	8⅓	9.7
80 x 40	120.7	0.6	250 x 150	220.7	4.4
3 x 2	4¾	1.3	10 x 8	8⅓	10.6
80 x 50	120.7	0.6	250 x 200	220.7	4.8
3 x 2½	4¾	1.3	12 x 8	9⅓	15.0
80 x 65	120.7	0.6	300 x 200	239.7	6.8
4 x 2	5½	1.8	12 x 10	9⅓	15.9
100 x 50	134.9	0.8	300 x 250	239.7	7.2
4 x 2½	5½	1.8			
100 x 65	134.9	0.8			

**STAINLESS STEEL FITTINGS**

TYPE 316

Stainless Steel Fittings, Type 316 are available.  
Please refer to Anvil's Stainless Steel Brochure  
pages 7 - 9 for additional information.



(Document number #078),

## Roll Groovers

### MODEL 1007 & 3007

#### ROLL GROOVERS



Model 1007



Model 3007

Gruvlok roll grooving technology is protected by U.S. Patents 5450738, 5570603, 5778715 & others pending.

Pipe Material	PIPE SIZE/WALL THICKNESS (SCHEDULE IN./DN MM)										
	2	2½	3	4	5	6	8	10	12	14	16
	50	65	80	100	125	150	200	250	300	350	400
Steel	Schedule 40										
Stainless Steel	Schedule 40S										
Copper						n/a		n/a		n/a	

#### NOTES:

(1) All wall thickness shown are the maximum wall thickness for the indicated pipe material.

(2) Minimum wall thickness for each pipe materials & size is:

Steel: 2" - 12" – Sch. 10, 14" & 16" Std. Wall

Stainless Steel: 2" - 12" – Sch. 10S requires optional roller sets

Copper: 2" - 2½" – Type M

3" - 8" – Type DWV

**NOTE:** Some sizes may require optional equipment.

(3) Contact a Anvil Representative for information on grooving alternate materials

#### MODEL 1007 & MODEL 3007 - STEEL PIPE GROOVING TIMES (MIN: SEC.)

PIPE SIZE (IN./DN MM) - SCH. 40 (STD. WALL) STEEL PIPE											
2	2½	3	4	5	6	8	10	12	14	16	
50	65	80	100	125	150	200	250	300	350	400	
0:20	0:20	0:25	0:30	1:00	1:20	1:35	1:50	2:20	2:40	3:00	

This chart shows approximate grooving times with the groover setup for the proper size and groove diameter and the pipe properly positioned on the groover. The times shown are average times from the start of rotation of the pipe in the grooving rolls to completed groove.

**MODEL 3006 & 3006C**

ROLL GROOVERS

**MODEL 3006 & MODEL 3006C - GROOVER CAPABILITY**

Pipe Material	Pipe Size/Wall Thickness (Schedule)								
	2	2½	3	4	5	6	8	10	12
	50	65	80	100	125	150	200	250	300
Steel	Schedule 40								.188" .219"
Stainless Steel	Schedule 40S						n/a	n/a	n/a
Copper	K, L, M & DWV						n/a	n/a	n/a

**NOTES:**

(1) All wall thickness shown are the maximum wall thickness for the indicated pipe material.

(2) Minimum wall thickness for each pipe materials & size is:

Steel: All sizes – Sch. 10

Stainless Steel: All sizes – Sch. 40S

Copper: 2", 2½" – Type M

3" - 6" – Type DWV

Note: The universal diameter gauge is part of the copper option or is available as a stand alone option

(3) Please contact a Anvil Representative for more information on grooving alternate materials & wall thickness.

**MODEL 3006 & MODEL 3006C - STEEL PIPE GROOVING TIMES (MIN: SEC.)**

Pipe Size (Inches)/Max Steel Pipe Wall Thickness							
2	2½	3	4	6	8	10	12
50	65	80	100	150	200	250	300
0:20	0:20	0:25	0:30	1:20	1:55	0:40	1:20

**GROOVING TIMES:** This chart shows approximate grooving times with the groover set-up for the proper size and groove diameter and the pipe properly positioned on the groover. The times shown are average times from the start of rotation of the pipe in the grooving rolls to completed groove.

Gruvlok roll grooving technology is protected by U.S. Patents 5450738, 5570603, 5778715 & others pending.

# Fitting Size O.D. Chart & Flow Data Frictional Resistance

## FITTING SIZE O.D. & FLOW DATA FRICTIONAL RESISTANCE (EXPRESSED AS EQUIVALENT STRAIGHT PIPE)

**GRUVLOK®**

Nominal Size	O.D.	Pipe Wall Thickness	Elbow		Tee	
			90°	45°	Branch	Run
In./DN(mm)	In./mm	In./mm	Ft./m	Ft./m	Ft./m	Ft./m
1	1.315	0.133	1.7	0.9	4.4	1.7
25	33.4	3.4	0.5	0.3	1.3	0.5
1½	1.660	0.14	2.3	1.2	5.8	2.3
32	42.2	3.6	0.7	0.4	1.8	0.7
1½	1.900	0.145	2.7	1.3	6.7	2.7
40	48.3	3.7	0.8	0.4	2.0	0.8
2	2.375	0.154	3.4	1.7	8.6	3.4
50	60.3	3.9	1.0	0.5	2.6	1.0
2½	2.875	0.203	4.1	2.1	10.3	4.1
65	73.0	5.2	1.2	0.6	3.1	1.2
3 O.D.	2.996	0.197	4.3	2.2	10.8	4.3
76.1	76.1	5.0	1.3	0.7	3.3	1.3
3	3.500	0.216	5.1	2.6	12.8	5.1
80	88.9	5.5	1.6	0.8	3.9	1.6
4¼ O.D.	4.250	0.220	6.4	3.2	16.1	6.4
108.0	108.0	5.6	2.0	1.0	4.9	2.0
4	4.500	0.237	6.7	3.4	16.8	6.7
100	114.3	6.0	2.0	1.0	5.1	2.0
5½ O.D.	5.236	0.248	8.0	4.0	20.1	8.0
133.0	133.0	6.3	2.4	1.2	6.1	2.4
5½ O.D.	5.500	0.248	8.3	4.2	20.9	8.3
139.7	139.7	6.3	2.5	1.3	6.4	2.5
5	5.563	0.258	8.4	4.2	21.0	8.4
125	141.3	6.6	2.6	1.3	6.4	2.6
6½ O.D.	6.259	0.280	9.7	4.9	24.3	9.7
159.0	159.0	7.1	3.0	1.5	7.4	3.0

Nominal Size	O.D.	Pipe Wall Thickness	Elbow		Tee	
			90°	45°	Branch	Run
In./DN(mm)	In./mm	In./mm	Ft./m	Ft./m	Ft./m	Ft./m
6½ O.D.	6.500	0.280	10.0	5.0	24.9	10.0
165.1	165.1	7.1	3.0	1.5	7.6	3.0
6	6.625	0.280	10.1	5.1	25.3	10.1
150	168.3	7.1	3.1	1.6	7.7	3.1
8	8.625	0.322	13.3	6.7	33.3	13.3
200	219.1	8.2	4.1	2.0	10.1	4.1
10	10.750	0.365	16.7	8.4	41.8	16.7
250	273.1	9.3	5.1	2.6	12.7	5.1
12	12.750	0.375	20.0	10.0	50.0	20.0
300	323.9	9.5	6.1	3.0	15.2	6.1
14	14.000	0.375	22.2	11.7	64.2	22.9
350	355.6	9.5	6.8	3.4	19.6	7.0
16	16.000	0.375	25.5	20.4	73.9	26.4
400	406.4	9.5	7.8	6.2	22.5	8.0
18	18.000	0.375	28.9	23.1	87.2	31.1
450	457.2	9.5	8.8	7.0	26.6	9.5
20	20.000	0.375	32.2	25.7	97.3	34.8
500	508.0	9.5	9.8	7.8	29.7	10.6
24	24.000	0.375	38.9	31.1	113.0	40.4
600	609.6	9.5	11.9	9.5	34.4	12.3

For the reducing tee and branches, use the value that is corresponding to the branch size. For example: for 6" x 6" x 3" tee, the branch value of 3" is 12.8 ft (3.9).

The Fitting Size Chart is used to determine the O.D. of the pipe that the fittings is to be used with. Gruvlok Fittings are identified by either the Nominal size in inches or the Pipe O.D. in/mm.

## TABLE OF CONTENTS

### INSTALLATION AND ASSEMBLY



The instructions are based on pipe grooved in accordance with Gruvlok® grooving specifications. Check pipe ends for proper groove dimensions and to assure that the pipe ends are free of indentations and projections which would prevent proper sealing.

**ALWAYS USE A GRUVLOK® LUBRICANT FOR PROPER COUPLING ASSEMBLY.** Thorough lubrication of the external surface of the gasket is essential to prevent pinching and possible damage to the gasket. For temperatures above 150°F (65.6° C) use Gruvlok Xtreme™ Lubricant and lubricate all gasket surfaces, internal and external. See Gruvlok Lubricants in the Technical Data section of the Gruvlok catalog for additional important information.

## TABLE OF CONTENTS

<b>FIG. 7001</b> Standard Coupling .....	150-151
<b>FIG. 7011</b> Standard Coupling .....	152-153
<b>FIG. 7401</b> Rigidlok® Coupling .....	154-155
<b>FIG. 7000</b> Standard Coupling .....	156-157
<b>FIG. 7400</b> Rigidlite® Coupling .....	158-159
<b>FIG. 7003</b> Hingelok™ Coupling .....	160-161
<b>FIG. 7010</b> Reducing Coupling .....	162-163
<b>FIG. 7012</b> Gruvlok Flange (2" - 12") .....	164-167
<b>FIG. 7012</b> Gruvlok Flange (14" - 24") .....	168-169
<b>FIG. 7042</b> Outlet Coupling .....	170-171
<b>FIG. 7045 &amp; FIG. 7046</b> Clamp-T® Branch Outlets .....	172-173
<b>FIG. 7044</b> Branch Outlet .....	174-175
<b>FIG. 7005</b> Roughneck® Coupling .....	176-177
<b>FIG. 7305</b> HDPE Coupling .....	178-179
<b>FIG. 7307</b> HDPE Transition Coupling .....	180-181
<b>FIG. 7312</b> HDPE Flange Adapter .....	182-183
<b>Gruvlok Sock-It® Fitting .....</b>	184-185
<b>FIG. GBV-S &amp; GBV-T</b> Circuit Balancing Valves .....	186-191
<b>FIG. AF21-GG, -GF &amp; -FF</b> AnvilFlex™ .....	192-193
<b>Weld-Miser™ Tee-Lets® .....</b>	194-197
<b>Eliminator Adjustable Drop Nipples .....</b>	198-200
<b>General Assembly of Threaded Fittings .....</b>	201
<b>Specified Bolt Torque .....</b>	202

**FIG. 7001**

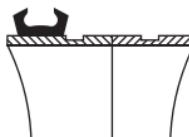
## STANDARD COUPLING

**1 Check & lubricate gasket—**

Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvllok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—** Slip the gasket over the pipe end making sure the gasket lip does not overhang the pipe end.

On couplings 10" and larger it may be easier to turn the gasket inside out-then lubricate and slide the gasket over the pipe end as shown.

**3 Alignment—** After aligning the two pipe ends, pull the gasket into position centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

On couplings 10" and larger, flip or roll the gasket into centered position.



**NOTE:** The housings for sizes 16" and larger are cast in four or more segments.

**TO INSTALL:** loosely pre-assemble the segments into two "Housing Halves" making sure that the alignment tang(s) and slot(s) on the bolt pad(s) are properly mated. Install the "Housing Halves" as shown in steps 4 & 5. The coupling is properly installed when all bolt pads are firmly together - Metal-to-Metal.

**FIG. 7001**

## STANDARD COUPLING



**4 Housings—** Place the coupling housing halves over the gasket making sure the housing keys engage the grooves. Insert bolts and turn nuts finger tight.

**5 Tighten Nuts—** Tighten the nuts alternately and equally to the specified bolt torque. The housing bolt pads must make metal-to-metal contact.

Uneven tightening may cause the gasket to pinch.

**6 Assembly is Completed—** Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7011**

## STANDARD COUPLING

**1** Inspect the pipe ends making sure the criteria, in the Gruvlok Large Diameter Pipe Roll and Cut Groove Specifications, are met.



**2** Turn the gasket inside out and slide the gasket completely over one of the pipe ends. Turning the gasket inside out will reduce the stretching necessary to put the gasket into position. Ideally, approximately 75% of the pipe's gasket-sealing surface, (Dimension A) should be visible when the gasket is in proper position. This will aid in step 4.



**3** Lubricate the gasket sealing lips. The use of Gruvlok lubricants ensures compatibility between the lubricant and the gasket.



**4** Pull the two pipes into contact aligning the pipe ends.

**CAUTION:** Be careful not to pinch fingers during this step. Working your way around the circumference of the pipe, flip the gasket toward the pipe end so that the proper side is facing out. The end of this procedure will result in the gasket snapping into place. Position the gasket centrally between the grooves of the two pipe ends.

**FIG. 7011, CONT'D.**

## STANDARD COUPLING



**5** Lubricate the exterior surface of the gasket. This helps prevent pinching of the gasket during assembly.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.



**6** Secure the housings about the pipes making sure the coupling keys are engaged in the pipe end grooves. Hint: For horizontal assembly, place housing segment on top of the pipe to support the weight of the housing segment. Secure the adjacent housing with an oval neck track bolt and heavy hex nut and then rotate the secured housings, again balancing the weight of the housings on the top of the pipe. Continue this procedure for all segments.



**7** Firmly torque each bolt. The specified minimum torque for each nut is 600 ft.-lbs. The specified maximum torque for each nut is 800 ft.-lbs.



**8** Installation of the Figure 7011 Standard Coupling is completed.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7401**

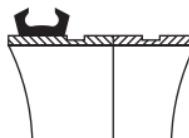
RIGIDLOK® COUPLING

**1 Check & lubricate gasket—**

Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok lubricant to outside and sealing lips of the gasket. Some applications require lubrication of the entire gasket surface. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—** Slip the gasket over the pipe end making sure the gasket lip does not overhang the pipe end.

On couplings 10" and larger it may be easier to turn the gasket inside out-then lubricate and slide the gasket over the pipe end as shown.

**3 Alignment—** After aligning the two pipe ends, pull the gasket into position centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

On couplings 10" and larger, flip or roll the gasket into centered position.



**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site - [www.anvilintl.com](http://www.anvilintl.com)

**NOTE:** Sizes 14" and larger are cast in multiple segments. To install the larger sizes align the tongue and pocket of the couplings appropriately and tighten the nuts alternately to the specified bolt torque. When properly assembled there will be a small equal gap between the adjacent bolt pads.

**FIG. 7401, CONT'D.**

RIGIDLOK® COUPLING



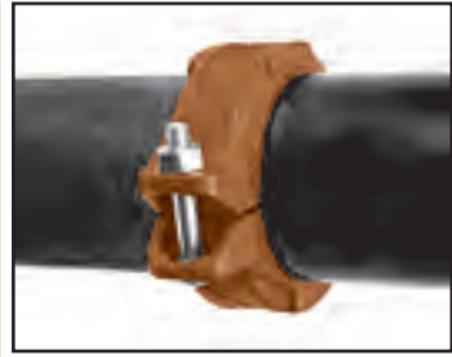
**4 Housings—** Remove one nut and bolt and loosen the other nut. Place one housing over the gasket, making sure the housing keys fit into the tube grooves. Swing the other housing over the gasket and into the grooves on both tubes, making sure the tongue and recess of each housing is properly mated. Re-insert the bolt and run-up both nuts finger tight.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.



**5 Tighten Nuts—** Securely tighten nuts alternately and equally to the specified bolt torque, keeping the gaps at the bolt pads evenly spaced.

**CAUTION:** Uneven tightening may cause the gasket to pinch. Gasket should not be visible between segments after bolts are tightened.



**6 Assembly is completed—** Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves. The bolt pads are to have equal gaps on each side of the coupling.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7000**

## STANDARD COUPLING

**1 Check & lubricate gasket—**

Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—**

Slip the gasket over the pipe end, making sure the gasket lip does not overhang the pipe end.

**3 Alignment—**

After aligning the two pipe ends together, pull the gasket into position, centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site - [www.anvilintl.com](http://www.anvilintl.com)

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**FIG. 7000, CONT'D.**

## STANDARD COUPLING



**4 Housings**— With one nut unthreaded to the end of the bolt, unthread the other nut completely and swing the coupling housing halves over the gasket, making sure the housing keys engage the grooves. Insert the bolt and turn the nuts finger tight.

**5 Tighten Nuts**— Tighten the nuts alternately and equally to the specified bolt torque. The housing bolt pads must make metal-to-metal contact.

**CAUTION:** Uneven tightening may cause the gasket to pinch.

**6 Assembly is completed**— Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7400**

RIGIDLITE® COUPLING

**1 Check & lubricate gasket—**

Check the gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok Xtreme Lubricant to the entire surface, both internal and external, of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—** Slip the gasket over the one tube, making sure the gasket lip does not overhang the tube end.

**3 Alignment—** After aligning the two tube ends together, pull the gasket into position, centering it between the grooves on each tube. The gasket should not extend into the groove on either tube.

**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site - [www.anvilintl.com](http://www.anvilintl.com)

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**FIG. 7400, CONT'D.**

## RIGIDLITE® COUPLING



**4 Housings—** Remove one nut and bolt and loosen the other nut. Place one housing over the gasket, making sure the housing keys fit into the tube grooves. Swing the other housing over the gasket and into the grooves on both tubes, making sure the tongue and recess of each housing is properly mated. Re-insert the bolt and run-up both nuts finger tight.

**5 Tighten Nuts—** Securely tighten nuts alternately and equally to the specified bolt torque, keeping the gaps at the bolt pads evenly spaced.

**CAUTION:** Uneven tightening may cause the gasket to pinch. Gasket should not be visible between segments after bolts are tightened.

**6 Assembly is completed—** Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves. The bolt pads are to have equal gaps on each side of the coupling.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7003**

HINGELOK™ COUPLING

**1 Check & lubricate gasket—**

Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvllok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—**

Slip the gasket over the pipe end making sure the gasket lip does not overhang the pipe end.

**3 Alignment—**

After aligning the two pipe ends, pull the gasket into position centering it between the grooves on each pipe. Gasket should not extend into the groove on either pipe.

**FIG. 7003, CONT'D.****HINGELOK™ COUPLING**

**4 Housings**—Put one half of the open coupling over the gasket as the coupling keys fit firmly into the grooves on each pipe end. Swing the other half of the coupling into position around the gasket and into the grooves.



**5 Lock coupling**—Fit the nose of the locking handle in the notch of the opposite housing. Press firmly down on the handle until it makes contact with the coupling housing. Insert locking pin into handle linkage to secure handle in closed position. (See Caution.)



**6 Assembly is completed**—Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.

**CAUTION:**

- 1) Hammering or banging on the handle or coupling housing could cause serious damage to the locking device and coupling assembly. The result may be an unsuitable pipe joint and unusable coupling assembly.
- 2) Care needs to be taken so that fingers do not get caught or pinched when handle is placed in locked position as a result of cam action of handle assembly.
- 3) When re-using coupling and gasket, always inspect gasket for damage and hinge/handle assembly for looseness, distortion or any other damage.

**FIG. 7010**

## REDUCING COUPLING

**1 Check & lubricate gasket—**

Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvllok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.

**2 Gasket Installation—** Place the smaller opening of the gasket over the smaller pipe. Angle the gasket over the pipe end and pull the gasket lip open around the circumference of the pipe. The center leg of the gasket should make flush contact with the pipe end and will prevent telescoping of the smaller pipe inside the larger.

**3 Alignment—** Align the adjoining pipe center lines, and insert the larger pipe end into the gasket. Angle the pipe end slightly to the face of the gasket and tilt the pipe into the gasket and tilt the pipe into the gasket to ease assembly.

**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site - [www.anvilintl.com](http://www.anvilintl.com)

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**FIG. 7010, CONT'D.**

## REDUCING COUPLING



**4 Housings**—Place the coupling housing halves over the gasket making sure the housing keys engage the grooves. Insert bolts and turn nuts finger tight.

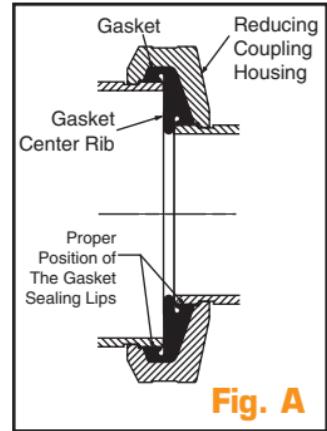


**5 Tighten Nuts**—Tighten the nuts alternately and equally to the specified bolt torque. The housing bolt pads must make metal-to-metal contact.

**CAUTION:** Uneven tightening may cause the gasket to pinch.



**6 Assembly Complete**—Visually inspect the pipe joint to assure the coupling keys are fully engaged in the pipe grooves and the bolt pads are in firm even metal-to-metal contact on both sides of the coupling.



**Fig. A**

**NOTE:** Fig. A illustrates the correct position of the Fig. 7010 Reducing Coupling gasket and housing properly assembled onto adjacent pipe ends.

**CAUTION:** In vertical installations the pipes must be supported to prevent telescoping during installation.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

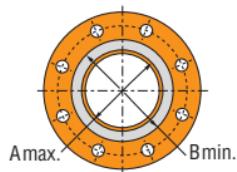
**FIG. 7012**

GRUVLOK FLANGE (2"–12")

**APPLICATIONS WHICH REQUIRE A GRUVLOK® FLANGE ADAPTER INSERT:**

1. When mating to a wafer valve (lug valve), if the valve is rubber faced in the area designated by the sealing surface dimensions (A Max. to B Min.), place the Gruvlok Flange Adapter Insert between the valve and the Gruvlok Flange.
2. When mating to a rubber-faced metal flange, the Gruvlok Flange Adapter Insert is placed between the Gruvlok Flange and the rubber-faced flange.
3. When mating to a serrated flange surface, a standard full-faced flange gasket is installed against the serrated flange face, and the Gruvlok Flange Adapter Insert is placed between the Gruvlok Flange and the standard flange gasket.
4. When mating to valves or other component equipment where the flange face has an insert, use procedure described in note 3.

Check pipe end for proper grooved dimensions and to assure that the pipe end is free of indentations and projections that would prevent proper sealing of the Gruvlok flange gasket.

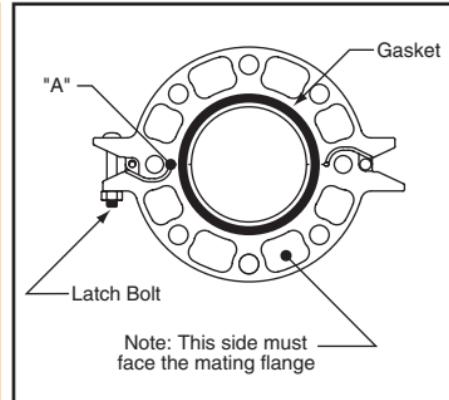
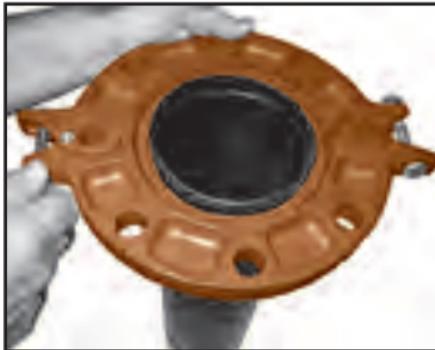


1 On the side without the hinge pin, loosen the latch bolt nut to the end of the bolt thread. (It is not necessary to remove the nut from the latch bolt.) Swing the latch bolt out of the slot. Open the Gruvlok Flange and place around the grooved pipe end with the key section fitting into the groove. The flange gasket cavity must face the pipe end.

**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site - [www.anvilintl.com](http://www.anvilintl.com)

**FIG. 7012, CONT'D.**

GRUVLOK FLANGE (2"-12")



**2** Place the latch bolt back into the slotted hole. Tighten the nut until there is a  $\frac{1}{16}$ " gap between the flange halves at location "A". (See Figure below)

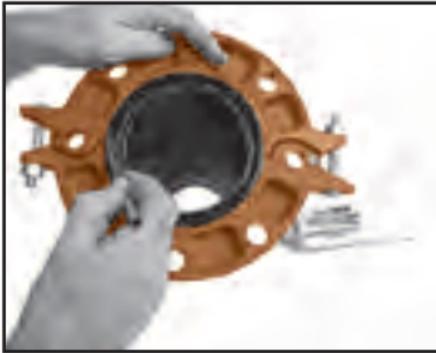
**3** Check the gasket to assure that it is properly suited for the intended service. Lubricate the entire exterior surface of the gasket, including the sealing lips, using the proper Gruvlok lubricant.



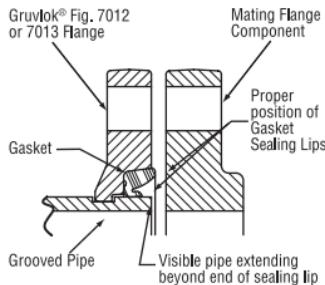
The Gruvlok Flange gasket must be inserted so that the sealing lips face toward the pipe end and the mating flange. The lip of the gasket, sealing on the pipe, should not extend beyond the pipe end. The pipe should extend out beyond the end of the sealing lip by approximately  $\frac{1}{8}$ " on the 2"-6" sizes and  $\frac{3}{16}$ " on the 8"-12" sizes.

**FIG. 7012, CONT'D.**

GRUVLOK FLANGE (2"-12")



- 4** Stretch the Gruvlok gasket around the pipe end and then press the gasket into the cavity between the pipe O.D. and the flange. The gasket must be properly positioned as shown in the figure below.



- 5** With the gasket in place apply lubricant to the exposed gasket tip, which will seal on the mating flange. **Tighten the nuts on the latch bolts alternately to the specified latch bolt torque. The flange housings must be in firm metal-to-metal contact.**

- 6** Verify that the mating flange face is hard, flat and smooth, free of indentations, which would prevent proper sealing of the Gruvlok Flange gasket. Assure the gasket is still in the proper position and align Gruvlok Flange bolt holes with the mating flange, pump, tank, etc., bolt holes.

**WARNING**

It is important to line up the bolt holes before bringing the two flanges together. Sliding the flanges into place will dislodge the gasket and cause leakage to occur. When using a flange insert, it is important that the insert is properly aligned with the gasket prior to tightening the bolts.

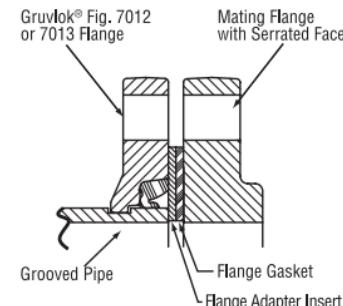
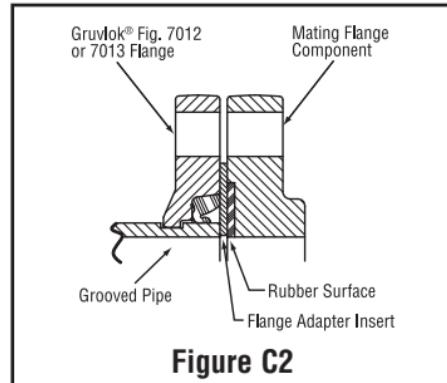
**FIG. 7012, CONT'D.**

GRUVLOK FLANGE (2"-12")



**7** Insert a flange bolt or stud with material properties of SAE J429 Grade 5 or higher through the bolt holes and thread a nut on hand tight. Continue this procedure until all bolt holes have been fitted. Tighten the nuts alternately and evenly so the flange faces remain parallel. All the bolts or studs must be torqued to the mating flange bolts specified torque. The flange faces should have metal-to-metal contact.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**Figure C1****Figure C2**

**NOTE:** The Gruvlok Fig. 7012 Flange requires the use of an Flange Adapter Insert when used against rubber surfaces (Figure C1), serrated flange surfaces or mating flanges with inserts (Figure C2). The Flange Adapter Insert will be exposed to the fluids in the system. Ensure that the Insert is compatible with the fluids in the systems and with adjacent piping components.

**WARNING**

Do not use a steel Flange Adapter Insert in copper systems or in systems where galvanic corrosion is possible.

**CAUTION:** Proper torquing of flange bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIG. 7012**

GRUVLOK FLANGE (14"-24")

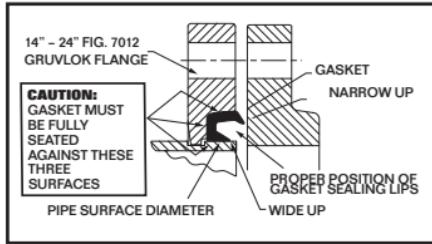
Gruvlok® Flanges of 14" size and larger are cast in four segments to ease handling during assembly.



**1** Place each Gruvlok Flange segment around the grooved pipe with the key section fitting into the groove and the flange gasket cavity facing the pipe end. Loosely assemble the segments using the four segment-bolts-and-nuts. Alternately and equally tighten the latch bolts and nuts to the specified latch bolt torque bring the four flange segments into full, firm metal-to-metal contact.

**NOTE:** An alternative method of assembly is to loosely preassemble two segments into two equal halves of the flange leaving a small gap (approximately 1/8") between the two segments of each flange-half. Place the flange halves around the pipe and complete the assembly as described in Step 1, above.

**2** Check the gasket grade to verify that it is properly suited for the intended service. Lubricate the entire surface of the gasket and the flange cavity using the appropriate Gruvlok Lubricant. The gasket may be shipped with the sealing lips facing outward. If so, it will be necessary to rotate the gasket so the narrow gasket lip (marked, "This face towards mating flange" on the 16"-24" sizes) is facing out as shown in figure Step 3. Place the Gruvlok Flange Gasket around the pipe end by pressing the gasket into the cavity between the pipe O.D. and flange recess. Move around the gasket in both directions until the gasket is fully seated in the flange gasket cavity.

**FIG. 7012, CONT'D.****GRUVLOK FLANGE (14"-24")**

**3** The correct position and relationship of the components of the Gruvlok Flange assembly is shown in the Figure above. The wide gasket lip must seal on the pipe surface diameter and the narrow gasket lip must face the mating flange. Be careful that foreign particles do not adhere to lubricated surfaces.

**NOTE:** Design of the Gruvlok Flange provides sealing only with the special Gruvlok Flange gasket. Only Gruvlok Flange gaskets may be used with Fig. 7012 flanges.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.



**4** Align the Gruvlok Flange bolt holes with mating flange bolt holes. Insert a flange bolt or stud with material properties of SAE J429 Grade 5 or higher through the bolt holes and thread a nut on hand tight. Insert the next bolt or stub opposite the first and again thread the nut on hand tight. Continue this procedure until all bolt holes have been fitted. Insertion of the flange bolts prior to contact of the flanges will help in the alignment of the flanges. Pull the two flanges into contact using care to assure that the gasket remains fully seated within the gasket cavity during assembly.

**NOTE:** Take care to assure that the gasket lip is not bent backwards and pinched between the two flanges.



**5** Tighten the nuts evenly to the specified mating face bolt torque so that the flange faces remain parallel and make firm even contact around the entire flange.

**CAUTION:** Proper torquing of flange bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7042****OUTLET COUPLING**

These instructions are based on pipe grooved in accordance with Gruvlok® grooving specifications. Check pipe ends for proper groove dimensions and to assure that the pipe ends are free of indentations and projections which would prevent proper sealing.



**1 Check & lubricate gasket**—Check gasket to be sure it is compatible for the intended service. Apply a thin coating of Gruvlok lubricant to outside and sealing lips of the gasket. Be careful that foreign particles do not adhere to lubricated surfaces.



**2 Gasket Installation**—Slip the gasket over one pipe end making sure the pipe abuts the gasket's center ribs.



**3 Alignment**—Align the pipe ends and pull the pipe into the gasket until the center ribs are in contact with the pipe ends. The gasket should not extend into the groove on either pipe. Rotate the gasket to align the outlet of the gasket to the same direction as the branch outlet.



**4 Housing Assembly**—With one nut and bolt removed and the other loosened, place one side of the housing over the gasket. Make sure the ribs on the outside of the gasket align with the recesses in the housing and the keys in the housing are in the grooves on both pipes. Swing the other housing over the gasket and into the grooves on both sides of the pipe. Make sure the recess in the outlet of the housing is properly aligned with gasket outlet.

ALWAYS USE A GRUVLOK LUBRICANT FOR PROPER COUPLING ASSEMBLY. Thorough lubrication of the gasket is essential to prevent pinching and possible damage to the gasket.

**FIGURE 7042, CONT'D**

## OUTLET COUPLING



**5 Tighten Nuts**—Re-insert the bolt and run-up both nuts finger tight. Securely tighten the nuts alternately and equally until they are completely tightened and there is no gap between the bolt pads. Continue tightening the nuts alternately and equally until the specified bolt torque is reached.

**CAUTION:** Make sure the ribs on the exterior of the gasket are enclosed in the housing recesses.

**6 Assembly is complete**

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**FIG. 7042 – SPECIFIED BOLT TORQUE**

Specified bolt torque is for the oval neck track bolts used on Gruvllok® couplings and flanges. The nuts must be tightened alternately and evenly until fully tightened.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7045 & 7046****CLAMP-T® BRANCH OUTLETS**

ALWAYS USE A GRUVLOK LUBRICANT FOR PROPER COUPLING ASSEMBLY.

Thorough lubrication of the gasket is essential to assist the gasket into the proper sealing position.

**1 Pipe Preparation**—Cut

the appropriate size hole in the pipe and remove any burrs. Be sure to remove the slug from inside the pipe. Clean the gasket sealing surface within  $\frac{5}{8}$ " of the hole and visually inspect the sealing surface for defects that may prevent proper sealing of the gasket.

**PIPE PREPARATION**

Branch Size (Inches)	Hole Saw Size (Inches) (+1/8, -0)
1/2, 3/4, 1	1 1/2
1 1/4, 1 1/2	2
2	2 1/2
2 1/2	2 3/4
3	3 1/2
4	4 1/2

**2 Check & Lubricate**

**gasket**—Check the gasket to be sure it is compatible for the intended service. Apply a thin layer of Gruvlok lubricant to the back surface of the gasket. Be careful that foreign particles do not adhere to the lubricated surfaces. Insert the gasket back into the outlet housing making sure the tabs in the gasket line up with the tab recesses in the housing.

**3 Gasket Installation**—

Lubricate the exposed surface of the gasket. Align the outlet housing over the pipe hole making sure that the locating collar is in the pipe hole.

**4 Alignment**—Align the

strap around the pipe, insert the bolts and tighten the nuts finger tight. Some sizes use a U-bolt design.

**FIGURE 7045 & 7046, CONT'D.**

CLAMP-T® BRANCH OUTLETS



**5 Tighten nuts**—Alternately and evenly tighten the nuts to the specified bolt torque.



**6 Assembly is complete**

**FIGS. 7045 & 7046—SPECIFIED BOLT TORQUE**

Specified bolt torque is for the oval neck track bolts and U-bolts used on the Gruvlok® Clamp-T's. The nuts must be tightened alternately and evenly until fully tightened.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7044**

## BRANCH OUTLET



**1 Pipe Preparation and Gasket Lubrication—** Cut a  $1\frac{3}{16}$ " hole in the pipe and remove any burrs. Be sure to remove the slug from inside the pipe. Clean the gasket sealing surface within  $\frac{5}{8}$ " of the hole and visually inspect the sealing surface for defects that may prevent proper sealing of the gasket. Remove the gasket from the housing and apply a thin layer of Gruvlok® lubricant to the back surface of the gasket. Be careful that foreign particles do not adhere to the lubricated surfaces. Insert the gasket back into the outlet housing making sure the tabs in the gasket line up with the tab recesses in the housing.

**2 Gasket Installation—** Lubricate the exposed surface of the gasket with Gruvlok® lubricant.

**3 Alignment—** Align the outlet housing over the pipe hole making sure that the locating collar is in the pipe hole.

**FIGURE 7044, CONT'D.**

BRANCH OUTLET

**4 Housing Assembly—**

Attach the U-bolt from the other side and fasten the nuts finger tight.

**5 Tighten Nuts —**

Making sure the fitting is properly located over the pipe hole, tighten the nuts alternately and evenly to the specified torque of 27 to 33 Lbs.-Ft. (37 to 45 N·M).

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**6 Assembly is Complete**

Visually inspect the assembly, the gasket will extrude out from under the housing.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7005**

## ROUGHNECK® COUPLING

**1** Make certain the pipe ends are free of indentations, projections, weld splatter, or other imperfections which could prevent proper sealing of the gasket.



**2** Mark each pipe at a distance from the pipe end according to the pipe run size. See the chart.

Pipe Size <i>In.</i>	Distance from pipe end for mark <i>In.</i>	Bolt Torque	
		Min. ( <i>Fl-lbs.</i> )	Max. ( <i>Fl-lbs.</i> )
2-2½	1	150	190
3-4	1	200	250
5-8	1¼	250	300
10	1¾	500	600
12	1¾	550	700
14-16	1¾	550	700



**3** Check the gasket color code to verify that the gasket grade is properly suited for the intended service. Apply a thin coating of Gruvlok Lubricant to the gasket lips and outside of the gasket and slip the gasket over one pipe. Make sure the gasket does not overhang the pipe end.

**4** Align the second pipe and while holding the pipe in the butted position slide the gasket back over the second pipe end. The gasket should be equally spaced between the lines scribed on each pipe.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**FIGURE 7005**

## ROUGHNECK® COUPLING



**5** Place each half of the Roughneck coupling over the gasket, making sure that the tongue on one housing half is aligned with the recess on the other housing half.



**6** Tighten the nuts alternately and uniformly until the required bolt torque is reached. See chart on previous page for bolt torque.

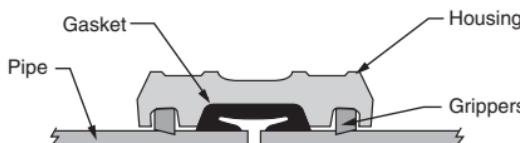
**7** Reinstallation after a disassembly will require that the threads on the bolt and in the nut are clean and lubricated with a light oil.

**NOTE:** Torque requirements must be met and housing halves must be assembled with equal gaps between bolt pads.

Working pressure and end load are based on a properly assembled Roughneck coupling with bolts fully torqued to the above specifications, on plain-end or beveled standard wall steel pipe and Gravlok Plain-End Fittings. Roughneck Couplings are designed to be used on plain-end pipe and Gravlok Plain-End Fittings only. For externally coated pipe applications, contact Gravlok.

Not recommended for use on steel pipe with a hardness greater than 150 Brinell, plastic, HDPE, cast iron or other brittle pipe.

\*Bolt torque ratings shown must be applied at installation.



**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7305**

HDPE COUPLING



**1** Make certain the pipe ends are free of indentations, projections or other imperfections, which could prevent proper sealing of the gasket. Mark each pipe at a distance from the end of the pipe according to the pipe size:

**Size Inches**

2-4" (51 - 102 mm)

5-8" (127 - 203 mm)

10&amp;12" (254 - 305 mm)

**Distance to Mark**

1" (25.4 mm)

1 1/4" (31.8 mm)

1 3/4" (44.5 mm)

**NOTE:** Make certain the HDPE pipe end is square cut to  $\frac{1}{8}$ " maximum for the 2" to 4" and  $\frac{5}{32}$ " maximum for the 6" and larger sizes.

**2** Check to assure the gasket material is acceptable for the intended service. The Gasket color code is green for EPDM and orange for Nitrile (Buna-N).

**CAUTION:** Use only Gruvlok Xtreme™ Lubricant with HDPE pipe products.

Gruvlok Xtreme™ Lubricant contains silicone. If silicone is unacceptable for the application contact Gruvlok for the lubrication recommendation. Apply a thin coating of Gruvlok Xtreme™ Lubricant to the gasket lip and outside surface of the gasket.

**3** Slip the gasket over one of the pipe ends. Make sure the gasket does not overhang the pipe end. Align the second pipe and while keeping the pipes in the butted position slide the gasket back over the second pipe end. The gasket must be positioned centrally between the lines on the pipe ends.

**WARNING**

- The gasket temperature rating may exceed the manufacturer's temperature rating for the HDPE pipe. Consult the HDPE pipe manufacturer for the temperature and pressure ratings.

**FIGURE 7305, CONT'D****HDPE COUPLING**

**4** Place the Figure 7305 housing casting over the gasket, making sure the tongue on one casting is aligned with the recess of the other casting.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.



**5** Insert the bolts and secure the nuts alternately and uniformly until the bolt pads are in contact. Torque all bolts to the required bolt torque levels. Refer to the Specified Bolt Torque Table. There is no gap between the bolt pads and the bolt torque should be within the range given when the coupling is properly assembled. Alternate and even tightening of the bolts will significantly reduce the torque needed to close the gap at the pipe joint.

**SPECIFIED BOLT TORQUE**

Specified bolt torque is for the oval neck track bolts used on Gruvlok® couplings. The nuts must be tightened alternately and evenly until fully tightened.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7307**

## HDPE TRANSITION COUPLING



**1** Make certain the HDPE pipe end is square cut to  $\frac{1}{8}$ " maximum for the 2" to 4" and  $\frac{5}{32}$ " maximum for the 6" and larger sizes. The steel pipe must be grooved in accordance with Gruvlok® Grooving Specifications for Steel Pipe. The pipe ends must be free of scratches, indentations, projections or other imperfections, which could prevent proper sealing of the gasket.



**2** Check to assure the gasket material is acceptable for the intended service. The Gasket color code is green for EPDM and orange for Nitrile (Buna-N).

**CAUTION:** Use only Gruvlok Xtreme™ Lubricant. Gruvlok Xtreme™ Lubricant contains silicone. If silicone is unacceptable for the application contact Gruvlok for the lubrication recommendation. Apply a thin coating of Gruvlok Xtreme™ Lubricant to the gasket lips and outside surface of the gasket.



**3** Slip the gasket over one of the pipe ends. Make sure the gasket does not overhang the pipe end. Align the second pipe and while holding it in the butted position, slide the gasket back over the second pipe end. The gasket must be positioned on the gasket seat surface of the grooved steel pipe. Make sure the gasket does not overhang into the pipe groove.

**WARNING**

- The gasket temperature rating may exceed the manufacturer's temperature rating for the HDPE pipe. Consult the HDPE pipe manufacturer for the temperature and pressure ratings.

FIGURE 7307, CONT'D  
HDPE TRANSITION COUPLING



**4** Place each half of the coupling housing over the gasket, making sure the housing grooved end is directed into the pipe groove.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.



**5** Insert the bolts and secure the nuts alternately and uniformly until the bolt pads are in contact. Torque all bolts to the required bolt torque levels. Refer to the Specified Bolt Torque Table. There is no gap between the bolt pads and the bolt torque should be within the range given when the coupling is properly assembled. Alternate and even tightening of the bolts will significantly reduce the torque needed to close the gap at the pipe joint.

### SPECIFIED BOLT TORQUE

Specified bolt torque is for the oval neck track bolts used on Gravlok® couplings. The nuts must be tightened alternately and evenly until fully tightened.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

**FIGURE 7312****HDPE FLANGE ADAPTER**

**1** Make certain the pipe end is square cut to  $\frac{1}{8}$ " maximum for the 4" and  $\frac{5}{32}$ " maximum for the 6" and 8" sizes. Inspect the surface of the mating flange to be assured the surface is free of dimensions of the mating flange to be assured that the scratches, indentations, projections, or other imperfections, which could prevent proper sealing of the gasket.

**2** Check to assure the gasket material is acceptable for the intended service. The gasket color code is green for EPDM and orange for Nitrile (Buna-N).

**CAUTION:** Use only Gruvlok Xtreme™ Lubricant with HDPE pipe Products. Gruvlok Xtreme™ Lubricant contains silicone. If Silicone is unacceptable for the application contact Gruvlok for the lubrication recommendation. Apply a thin coating of Gruvlok Xtreme™ Lubricant to the gasket lips and outside surface of the gasket.



**3** Place the housing over the end of the pipe and using a straight edge, align the face and the flange face with the end of the pipe. Do not let the pipe extend beyond the flange face.



**4** Tighten the housing nut until the housing bolt pads make firm metal to metal contact. Torque all bolts to the required latch bolt torque levels. Refer to the Specified Latch Bolt Torque Table.



- The gasket temperature rating may exceed the manufacturer's temperature rating for the HDPE pipe. Consult the HDPE pipe manufacturer for the temperature and pressure ratings.

**FIGURE 7312, CONT'D****HDPE FLANGE ADAPTER**

**5** Position the Gruvlok Flange gasket around the pipe end and press the gasket into the flange gasket pocket. Be sure the flange sealing lips are facing out.

**6** Align the Gruvlok Flange bolt holes with the mating flange bolt holes. Insert a standard bolt or stud through one bolt hole and thread the nut on hand tight. Insert the next bolt or stud opposite the first and thread the nut on hand tight. Continue this procedure until all holes have been fitted. Note: Take care to assure the gasket lip is not bent backwards and pinched between the two flanges.

**7** Tighten the flange face nuts alternately and evenly so that the flange faces remain parallel and make firm contact around the entire flange. Torque all bolts to the required mating flange joint torque levels. Refer to the Specified Mating Flange Bolt Torque Table.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**SPECIFIED BOLT TORQUE FOR LATCH & MATING FLANGE BOLTS**

Specified bolt torque is for the latch and mating flange bolts used on Gruvlok® flanges. The nuts must be tightened alternately and evenly until fully tightened.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation. Pipe joint separation may result in significant property damage and serious injury. See page 202 for bolt torque information.

## GRUVLOK SOCK-IT® FITTING



**1** Pipe surface shall be cleaned at least 1" from the end of the pipe to remove any coating, indentations, projections, and sharp edges which could affect proper gasket sealing. As a guide for installation, mark the pipe at a distance of 1½" from the end for 1", 1¼", and 1½" size fittings and 1¾" for the 2" & 2½" size fittings.

**NOTE:** When Allied XL pipe is used it is necessary only to remove sharp edges and burrs at the end of the pipe. No additional cleaning is required.

**2** Check all lock bolts to be sure they do not extend into the I.D. of the Sock-It Fittings as this would prevent proper insertion of the pipe.

**3** Apply a light coating of GRUVLOK Lubricant to the gaskets located in each end of the Sock-It Fitting. Also apply a light coating of lubricant to the pipe ends to further ease insertion of the pipe into the Sock-It Fitting.

**NOTE:** Use only Gruvlok Lubricants. Other lubricants may affect gasket performance.

**NOTE:** Refer to page 274 - 275 for additional technical information.

## GRUVLOK Sock-It® FITTING, CONT'D



**4** Insert the prepped and lubricated pipe end into the Sock-It Fitting until the pipe end makes contact with the internal pipe stop. A slight twist while pushing fitting and pipe together will ease the required insertion force. The end of the Sock-It Fitting should be within  $\frac{1}{16}$ " from the edge of the marking on the pipe. (See Step 1). Rotate the fitting until the desired position is obtained. Tighten the lock bolt until the bolt head bottoms against the threaded boss. (NOTE: The 2 1/2" Sock-It fitting has 2 locking bolts for each pipe end.)

Install the other prepped and lubricated pipe end into the Sock-It fitting in the same manner.

**CAUTION:** Do NOT hammer fitting on.

**NOTE:** Refer to page 274 - 275 for additional technical information.

**5** Sock-It Fittings may be removed by loosening the lock bolts. Re-installation may be accomplished as described in Steps 1-4.

**WARNING:** System pressure must be relieved and vented, and the system drained of fluid prior to loosening the lock bolts to remove or reposition the Sock-It Fitting.

Bolt end must be inspected to assure bolts ability to cut into pipe. Replace bolts in cases where bolt end sharpness has been compromised.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

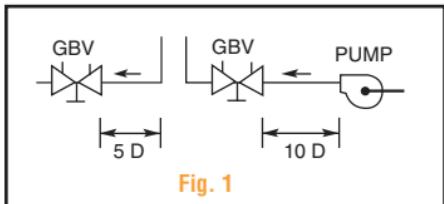
## FIGURE GBV-S & GBV-T

### CIRCUIT BALANCING VALVES

**1** Clean the system piping of debris (pipe scale, rust, welding slag) and other contaminants. As with any water system it is important to make provisions to keep the system clean. For optimum operation, air entrapment in the fluid must be removed.

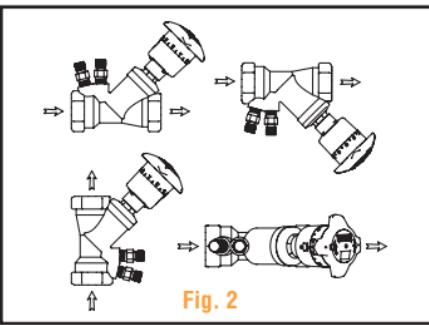
**2** The operation of the valve is dependent on the fluid characteristics such as specific gravity and viscosity, which vary with the fluid temperature. For installations using fluids other than 100% water, flow rates must be corrected for the changes created by the fluid medium. See [www.anvilintl.com](http://www.anvilintl.com) for appropriate correction factors, or call your local Anvil representative.

**3** To ensure accuracy of measurement Circuit Balancing Valves (GBV's) should be located at least five pipe diameters downstream from any fitting and at least ten pipe diameters downstream from a pump (as illustrated in Fig. 1).



**4** All GBV's are marked with an arrow on the valve body to indicate direction of flow. The arrow must point in the direction of flow for proper operation.

**5** GBV's may be installed in horizontal or vertical piping (as illustrated in Fig. 2). Provisions must be made for easy access to the probe metering ports (PMP's), reading scale, and memory stop.



### GBV-S - SWEAT (SOLDER) CONNECTIONS:

**6** GBV-S models are supplied with sweat style connections. Caution should be used when sweat style connection valves are installed to prevent overheating the valve.

**7** Solder the valve body in line using 95/5 (95% tin, 5% antimony) type solder or equal. Always follow local plumbing codes for installation best practices.

**CAUTION:** Before soldering, ensure the valve is opened at least one full turn to avoid damage to the sealing O-ring due to overheating. Anvil recommends that the GBV be protected during installation by wrapping a damp rag around the handle / bonnet assembly prior to soldering the valve into the line.

### GBV-T - NPT THREADED CONNECTIONS

**6** GBV-T models are tapped with NPT threaded connections. All threaded connections should be sealed using an approved pipe sealant per industry standards. Once the GBV installation has been completed and the system has been filled and purged, each valve loop must be adjusted to the correct flow setting. Employ piping best practice when engaging pipe to threaded valves. Overtightening when installing valves may result in fracturing of the valve body at the threads. (Go to Step 8)

## FIGURE GBV-S & GBV-T, CONT'D

### CIRCUIT BALANCING VALVES

**WARNING:** Anvil does NOT recommend leak testing an HVAC system with air due to safety concerns. Testing HVAC systems with pressurized air can be dangerous due to the high compressibility of air, as compared to water.

#### OPERATION:

**8** Valves are circuit balancing valves that are selected to deliver the correct flow in a piping circuit based on line size and design flow rate.

**9** To set the system flow, adjust the handwheel position until the differential pressure reading across the venturi corresponds to the required GPM.

**10** The valve operates from fully open to closed by a clockwise rotation of the orange handwheel using five 360° turns. Two indicators describe the position of the valve: the handwheel turns dial and the micrometer scale.

#### • “Handwheel Turns” Dial:

This dial is printed on the outer surface of a gearing mechanism located inside the lower half of the handle assembly (Fig.

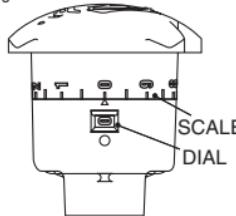
6). Each complete 360° revolution of the handwheel is visible through a display window and is scaled 0 - 5 to indicate the valve position in terms of the number of full turns. (Fig. 3)

#### • Micrometer Scale:

This scale is marked 0 - 9 and is located on the upper half of the handle assembly. Each mark represents  $\frac{1}{10}$ th of a full, 360° turn of opening when lined up with an arrowhead symbol, located above the handwheel turns display window. (Fig. 3)

**Fig. 3:** GBV setting

of 0.0 indicates that the valve is closed. Both the handwheel turns dial and the micrometer scale indicate a valve position reading of 0.

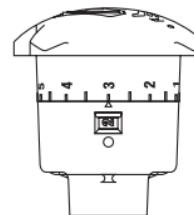


**11** The valve is considered “zeroed” when fully closed hand tight. The “0” on the micrometer scale should be within one half of

$\frac{1}{10}$ th of a turn of the arrowhead symbol when the valve is closed hand tight.

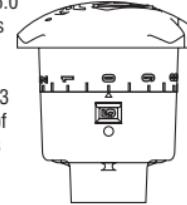
**DO NOT USE A WRENCH ON THESE VALVES – THEY SHOULD BE OPENED AND CLOSED HAND-TIGHT ONLY!**

**Fig. 4:** GBV setting of 2.3 indicates that the valve is partially open (2.3 turns open).



**Fig. 5:** GBV setting of 5.0 indicates that the valve is fully opened.

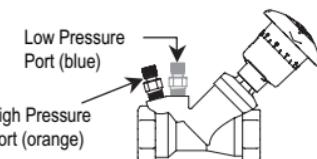
In some cases, the valve may open as much as 5.3 turns, due to the depth of the stem threads. This is not a problem with the valve; however, the performance curves for these GBVs are calibrated only to 5.0 turns.



**FIGURE GBV-S & GBV-T, CONT'D**

## CIRCUIT BALANCING VALVES

**CAUTION:** Hot water leakage can occur from metering ports (P.M.P.'s) during probe insertion and hookup of metering device. Wear protective eyewear and clothing to prevent personal injury when measuring pressure.



- 12** Connect pressure measuring device to the GBV metering ports as follows:
- Remove protective cap from metering ports (1/4" NPT connection).
  - Insert the meter probe into the metering ports. The hose with orange fitting, up stream; the hose with blue fitting downstream.

**CAUTION:** When inserting probe, do not bend, as this will cause permanent damage to the probe, adversely affecting the pressure measurement. Do not use any lubrication on the probes when inserting them. If necessary, simply wet the probes with clean water.

The probe should not be left inserted into the fitting for prolonged periods of time, overnight, etc., as leakage of the P.M.P. may occur when the probe is removed.

The locking nut on the probe is designed to hold it in the P.M.P. when taking readings. As sealing is accomplished internally on the probe stem, it is only necessary to tighten the locking nut FINGER-TIGHT. Over-tightening may cause damage to the P.M.P. or locking nut threads.

- 13** Before taking a measurement reading, set the valve to its fully open position (5.0) or at a preset position. Read the pressure drop across the venturi with a digital meter. Determine flow rate by use of venturi Cv performance curves on page 4 or the Anvil Balancing Slide Rule.

- 14** The handle of the GBV is not designed to be removable. Do not try to take it off

the valve, or it may become damaged. If for any reason, the handle is damaged, replace the entire handle / stem assembly with the appropriate replacement part indicated in the table below.

**Table 1**

PART NUMBER	SIZE
871158-010	1/2"
871158-011	3/4"
871158-012	1"
871158-013	1 1/4"
871158-014	1 1/2"
871158-015	2"

**MEMORY SETTING:**

- 15** After valve has been properly adjusted and without moving the handwheel, the locking memory stop should be set. The memory stop will allow the valve to be fully closed for isolation and then reopened to the preset flow position.

- 16** Insert a 2.5 mm (or 3/32") Allen key through the hole provided in the valve's handle cap. (Fig. 6)

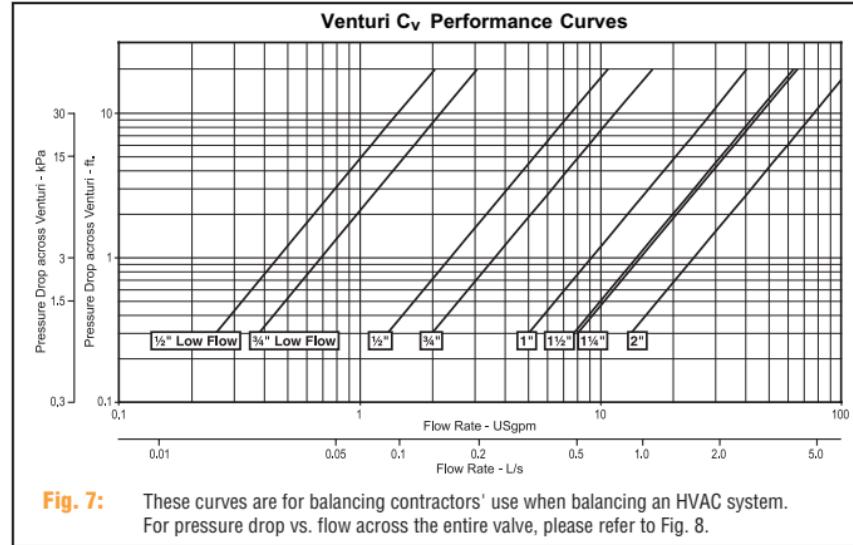
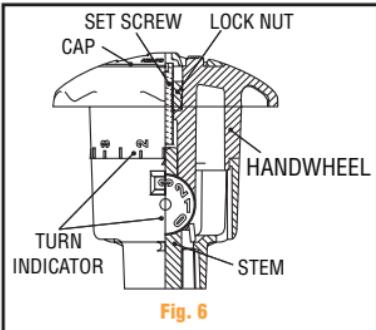
- 17** Turn the setscrew in a clockwise direction until it stops. It is not necessary to

## FIGURE GBV-S & GBV-T, CONT'D

### CIRCUIT BALANCING VALVES

tighten. The memory has now been set. This establishes the maximum opening position for this particular valve.

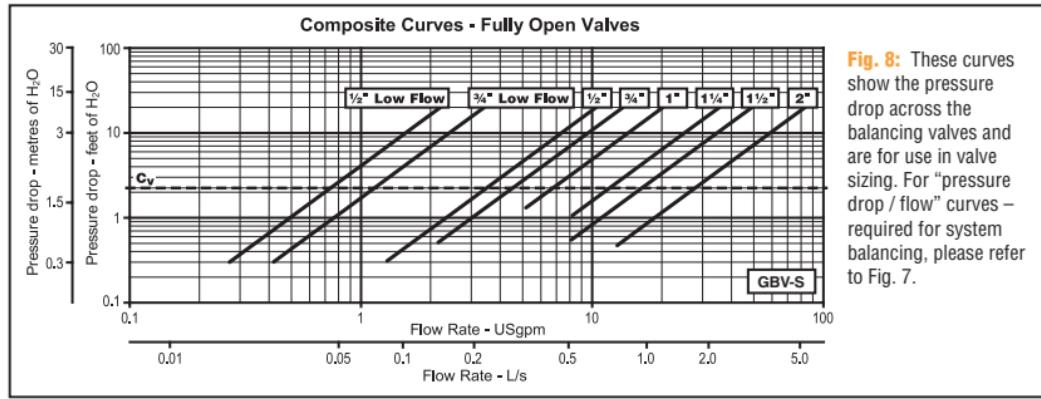
**18** The valve may now be closed tightly, as needed, for isolating the piping during system maintenance. To return the valve to its preset "balanced" position, simply open the valve by turning the handwheel counter-clockwise until the handle stops turning (the valve stem inside the handle has hit the memory setscrew). DO NOT APPLY EXCESSIVE FORCE WHEN REOPENING THE VALVE – OPEN ONLY UNTIL THE VALVE STOPS TURNING UNDER "HAND TIGHT" CONDITIONS. DO NOT USE A WRENCH TO OPEN, CLOSE, OR TIGHTEN VALVES.



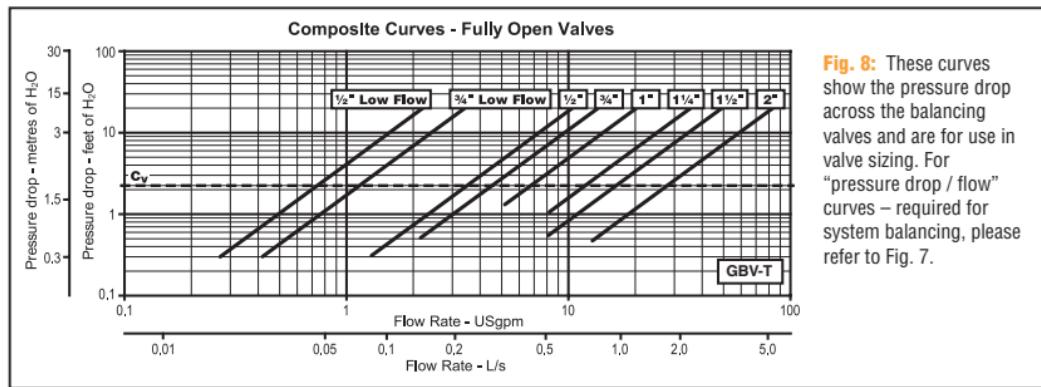
See next two pages for Fig. 8 for both the GBV-S & GBV-T and a troubleshooting chart

**FIGURE GBV-S & GBV-T, CONT'D**

## CIRCUIT BALANCING VALVES



**Fig. 8:** These curves show the pressure drop across the balancing valves and are for use in valve sizing. For "pressure drop / flow" curves – required for system balancing, please refer to Fig. 7.



**Fig. 8:** These curves show the pressure drop across the balancing valves and are for use in valve sizing. For "pressure drop / flow" curves – required for system balancing, please refer to Fig. 7.

**FIGURE GBV-S & GBV-T, CONT'D**

## CIRCUIT BALANCING VALVES

**TROUBLESHOOTING:**

Symptom	Likely Cause	Solution
<b>1. Valve is leaking:</b>		
• At the bonnet / body joint	Bonnet O Ring has been damaged.	Remove the handle / stem assembly and replace with the appropriate replacement part indicated in Table 1.
• At the pipe connection	If solder joint - the joint has failed, or was not soldered properly.  If threaded - the connection is not sufficiently tight, or  the valve was over-tightened during installation and the valve body has cracked (fractured).	Re-solder the connection and recheck for leakage.  Tighten and recheck for leakage.  Remove and reinstall a new valve, being careful not to over-tighten.
<b>2. Valve does not shut off completely when closed (hand tight).</b>	The seat O ring has been deformed due to overheating during soldering.	Remove the handle / stem assembly and replace with the appropriate replacement part indicated in Table 1.

**FIGURE AF21-GG, AF21-GF & AF21-FF**

## ANVILFLEX™ FLEX CONNECTORS

**Installation**

**1** Avoid torque. Do not twist the hose assembly during installation when aligning the bolt holes in a flange or in making up pipe threads. The utilization of lap joint flanges or pipe unions will minimize this condition.

**2** To install a thread end braided metal hose assembly unions must be used. Do not place wrenches on the braided portion or the collar of the braided metal hose assembly. Use care not to torque the braided metal hose assembly while tightening the union. It is recommended that two wrenches be used in making the union connection; one to prevent the hose from twisting and the other to tighten the coupling.

**3** Install the braided metal hose assembly with neutral face-to-face dimension as shown on the submittal drawing. Do not install a braided metal hose assembly compressed (bagged braid). The corrugated inner hose contains the fluid, the braid is designed to take the stress of system pressurization and contain the core.

**4** If the braided metal hose assembly must be installed with an initial offset then the maximum allowable movement is reduced by the amount of the initial deflection.

**5** Avoid over bending. The repetitive bending of a hose assembly to a radius smaller than the radius specified will result in early hose failure. Always provide sufficient length to prevent over bending and to eliminate strain on the hose assembly. Utilize sound geometric configurations that avoid sharp bends, especially near the end fittings of the assembly.

**6** Verify that the movements of the system are within the design parameters of the braided metal hose assembly being installed.

**7** Prevent out-of-plane flexing in an installation. Always install the hose assembly so that the flexing takes place in only one plane - - this being the plane in which the bending occurs

**8** The maximum system test pressure must not exceed 150% of the maximum rated working pressure as shown

**9** Check system pressure and temperature and do not exceed recommended performance limits. Operation beyond design limits will result in premature failure.

**10** The corrugated metal hose alloy must be chemically compatible with the media in the piping system. If in doubt as to suitability, refer to a Chemical Resistance Data table or contact your Anvil Rep. for guidance.

**11** The flanges on a concentric increasing braided metal hose assembly have the bolt holes straddling the hose centerline. The mating flanges should also straddle the centerline to avoid torque on the braided metal hose assembly.

**12** When installing weld end, or sweat end, braided metal hose assemblies, or when welding in the area of a braided metal hose assembly, extreme care is necessary in ensure no weld spatter comes in contact with the braided hose sections.

**FIGURE AF21-GG, AF21-GF & AF21-FF, CONT'D****ANVILFLEX™ FLEX CONNECTORS**

**13** A piping system, which utilizes braid-ed metal hose to absorb movement, must be properly anchored and/or guided. Always support the piping to prevent excessive weight from compressing the hose and relaxing the braid tension.

**14** Use care when handling the braided metal hose assembly during transpor-tation, storage, and installation. The braided hose sections must not be allowed to bend, deflect, sag, or otherwise extend beyond their rated capabilities.

**15** The shipping sticks, on flanged units, are to keep the braided metal hose assembly in its neutral end-to-end dimension during shipping and installation. After installation, the shipping sticks should be removed.

**Maintenance**

**1** The braided metal hose assembly should be inspected during routine maintenance to ensure there are no signs of external damage. Inspect for frayed or broken braid wires. Also inspect to ensure there is no damage to the hose. In the event that such damage is found, the braided metal hose assembly should be replaced.

**2** During system shutdown braided metal hose assembly should be examined to verify no thermal axial motion has occurred causing compression of the as-sembly.

**PROPER  
INSTALLATION****IMPROPER  
INSTALLATION  
PARALLEL****IMPROPER  
INSTALLATION  
COMPRESSED**

## WELD-MISER™ TEE-LETS®

### RECOMMENDED INSTALLATION PROCEDURES

Merit Weld-Miser Tee-Let Welding Outlet Fittings are designed and manufactured to reduce the cost of installation from both the standpoint of labor required and energy consumed. In addition, by following the recommended installation procedures, many of the problems associated with installing welding outlet fittings on standard weight or light weight pipe are eliminated, including burn through and excessive shrinkage resulting in pipe distortion.

### RECOMMENDED HOLE SIZES

The hole cut in the branch or header pipe can be cut prior or subsequent to attachment of the Tee-Let. One advantage of cutting the hole after welding is that the pipe is left intact during welding thereby reducing shrinkage and possible distortion. If holes are cut prior to welding, as some codes require, then the following hole sizes are recommended. Note that the same hole diameter for a given outlet size is required for both Type A and Type C Tee-Lets 1-1½" larger.

### RECOMMENDED WELDING PROCEDURES

Merit Weld-Wiser Tee-Lets are designed to be installed on standard weight or light weight pipe with one weld pass on Type A outlet sizes from ½" through 2½" inclusive, and on Type C outlet sizes through 4". Moreover, the wall thickness at the weld end of the fitting approximately matches standard weight pipe. Accordingly, heat setting can be made to optimize penetration on both the fitting and the pipe which it is being welded. Aside from reducing the likelihood of burn through and distortion resulting from excessive heat, the amount of weld required for adequate penetration is significantly reduced.

Merit Tee-Lets are manufactured from continuous cast aluminum killed steel with a carbon range of from 0.05 to 0.25. Merit specifies that residuals, such as chrome, nickel and other metals resident in the scrap used for production of the steel be reported and kept to a minimum. On the other hand, certain grades of carbon steel pipe are manufactured from scrap whose

RECOMMENDED TEE-LET HOLE SIZES		
Tee-Let Size	Type	Recommended Hole Size
In./mm		In./mm
½	Type A	5/8
13		16
¾	Type A	7/8
19		22
1	Type A	1 1/8
25		28
1¼	Type A	1 ½
31		38
1¼	Type C	1 ¾
31		35
1½	Type A or C	1 ½
38		41
2	Type A or C	2
50		50
2½	Type A or C	2 ½
63		61
3	Type A or C	3
75		75
4	Type A or C	4
100		100

Holes may be cut employing mechanical means—including hole sawing, mechanical flame cutting (oxy-acetylene or propane), and air plasma cutting (constricted tungsten arc) machines. Merit offers a simple approach to cutting the hole. Hand-held templates are sized to match your plasma cutter.

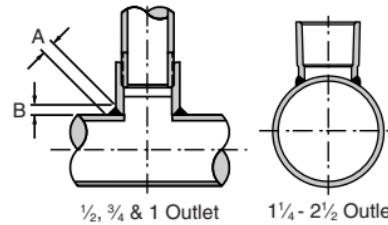
## WELD-MISER™ TEE-LETS®, CONT'D.

chemical composition is not specified. When the metal inert gas shield (MIG) welding process is employed, certain residuals may cause excessive porosity, spatter or lack of penetration. Specifically, gases released during the welding process do not escape before the molten puddle sets up.

When porosity or lack of penetration occurs, one approach is to slightly increase the heat in order to give the gases time to escape from the puddle. A flux cored wire can also be used. This wire contains scavengers which allow gases in the molten weld puddle to escape before the weld solidifies. The following recommended settings for welding therefore may need to be adjusted slightly higher if any of the above mentioned adverse conditions exist.

As a general rule, the weld should be only as hot as required to allow the weld to

penetrate the materials being welded while concomitantly allowing gases developed in the welding process to escape. Every effort must be made to avoid welding too hot or overheating both the pipe and the Tee-Let. **Excessive heat may cause the wrench tight threads (those in the bottom of the Tee-Let near the weld zone) to distort while also causing the branch pipe to bend.** It should be noted that Merit Tee-Lets have been subjected to exhaustive testing and evaluation, and only negligibly distort when subjected to excessive heat. The threads, on the other hand, may not return to their gauged form after cooling if excessive heat causes them to expand. The following is intended only as a guide, and assumes that the welding equipment is properly calibrated and functioning normally and the operator is qualified.



RECOMMENDED AMOUNT OF WELD		
Outlet Size	A	B
In./mm	In./mm	In./mm
1/2	1/4	3/16
13	7	5
3/4	1/4	3/16
19	7	5
1	1/4	3/16
25	7	5
1 1/4	1/4	3/16
31	7	5
1 1/2	5/16	1/4
38	8	7
2	5/16	1/4
50	8	7
2 1/2	5/16	1/4
63	8	7
3	3/8	5/16
75	10	5
4	3/8	5/16
100	10	5

RECOMMENDED SETTINGS FOR MICROWIRE WELDING PROCESS, CONTINUED ON NEXT PAGE							
Header Size	Pipe Wall Thickness	Tee-Let Types A, B, C	Electrode Size	Welding Current	Arc. Volts	Wire Feed	Travel Speed
In./mm	In./mm	In./mm		AMPS-DC	POS.	IPM	IPM
<i>1 1/4 - 2 31-50</i>	0.065 <i>2</i>	<i>1/2 - 2 13-50</i>	0.035	100-130	16-20	210	25-30
		<i>2 1/2 - 4 63-100</i>	0.035	115-150	17-21	270	20-25
	0.109 <i>3</i>	<i>1/2 - 2 13-50</i>	0.035	110-140	18-22	220	25-30
		<i>2 1/2 - 4 63-100</i>	0.035	120-160	19-22	290	20-25
	0.083 <i>2.5</i>	<i>1/2 - 2 13-50</i>	0.035	110-140	17-20	210	20-25
		<i>2 1/2 - 4 63-100</i>	0.035	120-150	17-20	270	20-25
<i>2 1/2 - 4 63-100</i>	0.120 <i>3</i>	<i>1/2 - 2 13-50</i>	0.035	120-160	19-22	290	20-25
		<i>2 1/2 - 4 63-100</i>	0.035	130-160	19-22	240	20-25
	0.109 <i>3</i>	<i>1/2 - 2 13-50</i>	0.035	120-150	17-20	210	20-25
		<i>2 1/2 - 4 63-100</i>	0.035	130-150	18-20	270	15-20
	0.134 <i>3.5</i>	<i>1/2 - 2 13-50</i>	0.035	130-160	19-22	290	20-25
		<i>2 1/2 - 4 63-100</i>	0.035	140-160	20-22	270	15-20
		<i>2 1/2 - 4 63-100</i>	0.045	180-205	20-24	245	27-32

## RECOMMENDED SETTINGS FOR MICROWIRE WELDING PROCESS, CONTINUED FROM PREVIOUS PAGE

Header Size	Pipe Wall Thickness	Tee-Let Types A, B, C	Electrode Size	Welding Current	Arc. Volts	Wire Feed	Travel Speed
In./mm	In./mm	In./mm		AMPS-DC	POS.	IPM	IPM
8 200	0.109 3	½ - 2 <i>13-50</i>	0.035	120-150	17-20	240	20-25
		2½ - 4 <i>63-100</i>	0.035	130-150	18-20	260	15-20
		2½ - 4 <i>63-100</i>	0.045	170-220	18-22	290	12-18
	0.148 3.5	½ - 2 <i>13-50</i>	0.035	130-160	19-22	240	20-25
		2½ - 4 <i>63-100</i>	0.035	140-160	20-22	260	15-20
		2½ - 4 <i>63-100</i>	0.045	180-225	20-24	290	12-18

## SHIELDING GAS FLOW (for all sizes) 20-25 CFH

- 1.) Co<sub>2</sub> - Deeper penetration, faster welding, low cost.
- 2.) 25% - Argon, 75% - Co<sub>2</sub>, Recommended for .134 wall and lighter, high welding speeds without meltthrough, minimum distortion and spatter, good penetration.

Merit assumes no liability for any consequential damages resulting from the improper use of its Tee-Let Welding Outlet Fittings, nor for any recommendations made with respect to installation procedures.

## INSTALLATION

- A) For use in wet and dry pipe automatic sprinkler systems installed in accordance with all applicable standards or codes. (See item 4)
- B) Before starting the job of making sprinklers into steel threads of the above fittings, count the number of fully developed male threads on the brand of sprinkler to be installed into the fittings. If seven (7) perfect threads are counted, the sprinkler should thread into the  $\frac{1}{2}$ " or  $\frac{3}{4}$ " thread from three (3) to four (4) threads hand tight. If five (5) to six (6) threads are counted, the sprinkler should thread into the  $\frac{1}{2}$ " or  $\frac{3}{4}$ " thread from two (2) to three (3) threads hand tight.
- C) Use an anaerobic pipe thread sealant for thread make-up. Apply pipe thread sealant only to male threads on the nipple and sprinkler only.
- D) If either of the above fails to allow the sprinkler to make-up to a minimum of from five (5) to six (6) full threads, do not overtighten the sprinkler. Instead back the sprinkler out of the fitting. Clean any debris and/or pipe sealant from both the male and female threads. Gauge both the male threads of the sprinkler and the female threads of the Adjustable Drop Nipple for compliance with ANSI B1.2.1. Specification for Tapered Pipe Threads. The same procedure would apply if a leak has been detected.  
  
If within tolerance, reapply the anaerobic pipe sealant and make-on to the required length. Refer to the pipe chart on the page 200 for correct make-up lengths. Allow twenty-four hours for setting.

- E) Connect the Adjustable Drop Nipple assembly to the sprinkler system by wrenching on the make-up area on the Drop Nipple **DO NOT WRENCH ON THE BARREL PORTION OF THE UNIT OR SPRINKLER**. Damage to the Adjustable Drop Nipple or Sprinkler may result.
- F) After the ceiling has been installed adjust the sprinkler to its final position by using the sprinkler wrench and assemble the escutcheon plate to the inner support ring. It is recommended that the system pressure be relieved when adjusting, however it is not necessary to drain the system.

## 1) GENERAL DESCRIPTION

Merit Eliminator Adjustable Drop Nipples Models "M" and "F" are the screw type consisting of an outer case which has one (1) inch N.P.T. or ISO-7 male or female thread on the inlet, and an inner case which has either a one-half inch ( $\frac{1}{2}$ ") or a three-quarter inch ( $\frac{3}{4}$ ") N.P.T. sprinkler connection. The inner case employs O-Ring Seals and adjusts either in or out over the range of the adjustment.

Merit Eliminator Adjustable Drop Nipples are designed for use in automatic fire sprinkler systems installed in accordance with all applicable standards or codes. (See item 4).

## ELIMINATOR ADJUSTABLE DROP NIPPLES, CONT'D

The purpose of these fittings is to allow for the final adjustment of the drop nipple between a branch line and a pendant sprinkler by eliminating the need to re-cut the existing drop nipple in order to fit-up flush to the ceiling. Merit Eliminator Adjustable Drop Nipples do not require any secondary locking following final adjustment and they will not extend as a result of vibrations or pressure surges in the system.

### 2) APPROVALS AND STANDARDS

Merit Eliminator Adjustable Drop Nipples are listed by the Underwriters Laboratories, Inc. (UL Listing Number 57SO) and approved by the Factory Mutual Research Corporation (FM). In addition, Model "M" and "F" Adjustable Drop Nipples are approved by the New York Board of Materials and Equipment Standard (BSA-886-86-5A) and verband der Schadenversicherer e.V., (Vds).

### 3) TECHNICAL DATA

Merit Adjustable Drop Nipples are rated for use at a maximum temperature of 300° F, and a maximum service pressure of 300 psi.

The approximate friction loss based on the Hazen and Williams Formula expressed in equivalent length of one (1) inch, schedule 40 pipe (where C= 120) is 1' for 1/2" outlet Model 'M', 2.6' for 3/4" outlet Model 'M', 4.2' for F1, 1.3' for F2, 1.5' for F3.150, and 2.9' for F3.175.

Merit Eliminator Drop nipples maximum sprinkler orifice size for Models M3.150, ME3.150, M1.150, and F3.150 is 17/32" and Models F1.150, F2.150, F3.175 and M3.175 is 5/8".

The inlet and outlet threads conform to ANSI B1.20.1 / ISO-7R/RC.

The O-Ring seals used in the manufacture are an ethylene propylene elastomer (EPDM). The outer and inner casings are manufactured from high strength carbon Steel.

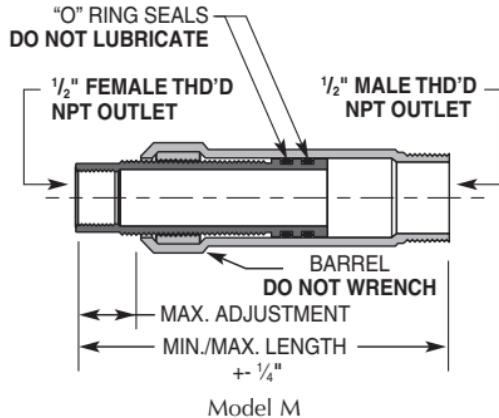
All Model "M" and "F" Adjustable Drop Nipples are hydrostatically tested for o-ring integrity prior to shipment.

### 4) WARNING

Adjustable Drop Nipples described herein must be installed and maintained in compliance with this document as well as the applicable standards of the National Fire Protection Association in addition to the standards for any other authorities having jurisdiction. DO NOT USE ANY PETROLEUM BASED LUBRICANTS ON THE O-RING SEALS. Petroleum based lubricants are incompatible with EPDM and will impair serviceability of the unit.

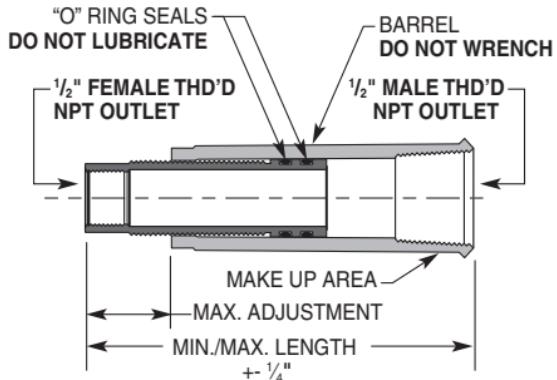
### 5) DIMENSIONAL DATA

See chartson next page.

ELIMINATOR ADJUSTABLE DROP NIPPLES, CONT<sup>I</sup>D

Model M

MODEL M DIMENSIONAL DATA					
Model #	Inlet	Outlet	Min. Length	Max Length	Max. Adjust
	In./mm	In./mm	in./mm	in./mm	in./mm
M1.150	1 Male 25	1/2 Female 13	4 1/8 105	5 1/8 130	1 25
M3.150	1 Male 25	1/2 Female 13	6 1/8 156	9 1/8 232	3 76
ME3.150	1 Male 25	1/2 Female 13	7 1/8 200	10 1/8 276	3 76
M3.175	1 Male 25	3/4 Female 19	8 1/8 206	11 1/8 283	3 76

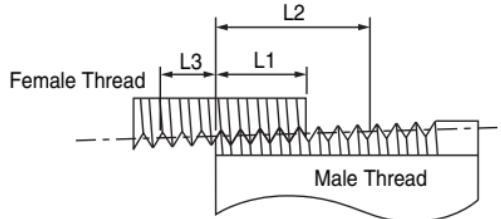


Model F

MODEL F DIMENSIONAL DATA					
Model #	Inlet NPT or DIN	Outlet NPT	Min. Length	Max Length	Max. Adjust
	In./mm		in./mm	in./mm	in./mm
F1.150	1 Female 25	1/2 Female 13	3 1/2 89	4 1/2 114	1 25
F2.150	1 Female 25	1/2 Female 13	4 1/2 114	6 1/2 165	3 76
F3.150	1 Female 25	1/2 Female 13	5 1/2 14	8 1/2 216	3 76
F3.175	1 Female 25	3/4 Female 19	7 5/16 186	10 5/16 262	3 76

## GENERAL ASSEMBLY OF THREADED FITTINGS

- 1) Inspect both male and female components prior to assembly.
  - Threads should be free from mechanical damage, dirt, chips and excess cutting oil.
  - Clean or replace components as necessary.
- 2) Application of pipe dope
  - Use a pipe dope that is fast drying, sets-up to a semi hard condition and is vibration resistant. Alternately, an anaerobic sealant may be utilized.
  - Thoroughly mix the thread sealant prior to application.
  - Apply a thick even coat to the male threads only. Best application is achieved with a brush stiff enough to force sealant down to the root of the threads.
- 3) Joint Makeup
  - For sizes up to and including 1½" pipe, wrench tight makeup is considered three full turns past hand tight. Hand tight engagement for ½" through 2" thread varies from 4.48 turns to 5.01 turns.
  - For 2½" through 4" sizes, wrench tight makeup is considered two full turns past hand tight. Hand tight engagement for 2½" through 4" thread varies from 5.46 turns to 6.75 turns.



NPT TAPERED PIPE THREADS—Length of Effective Threads				
Drop Nipple or Tee-Let Outlet Size	L1 Dim. Hand Tight	L3 Dim. Wrench Tight	Total L1 + L3 Length	L2 Dim. Effective Threads
In./mm	In.(mm)/Thrds	In.(mm)/Thrds.	In.(mm)/Thrds	In.(mm)/Thrds
½	0.320/4.48	0.214/3.00	0.534/7.48	0.534/7.47
13	2.6	5.4	13.6	13.6
¾"	0.339/4.75	0.214/3.00	0.553/7.75	0.546/7.64
19	8.6	5.4	14.0	13.9
1	0.400/4.60	0.261/3.00	0.661/7.60	0.683/7.85
25	10.2	6.6	16.8	17.3
1¼"	0.420/4.83	0.261/3.00	0.681/7.83	0.707/8.13
31	10.7	6.6	17.3	18.0
1½"	0.420/4.83	0.261/3.00	0.697/7.83	0.724/8.32
38	10.7	6.6	17.1	18.4
2	0.436/5.01	0.261/3.00	0.706/8.01	0.757/8.70
50	11.1	6.6	17.9	19.2
2½"	0.682/5.46	0.250/2.00	0.932/7.46	1.138/9.10
63	17.3	6.4	23.7	28.9
3	0.766/6.13	0.250/2.00	1.016/8.13	1.200/9.50
75	19.5	6.4	25.8	30.5
4	0.844/6.75	0.250/2.00	1.094/8.75	1.300/10.40
100	21.4	6.4	27.8	33.0

## SPECIFIED BOLT TORQUE

Specified bolt torque is for the oval neck track bolts used on Gruvlok® couplings and flanges. The nuts must be tightened alternately and evenly until fully tightened.

**NOTE:** Specified torques are to be used unless otherwise noted on Product Installation Instructions.

**CAUTION:** Use of an impact wrench is not recommended because the torque output can vary significantly due to many variables including air pressure supply, battery strength and operational variations.

**CAUTION:** Proper torquing of coupling bolts is required to obtain specified performance. Over torquing the bolts may result in damage to the bolt and/or casting which could result in pipe joint separation. **Under torquing the bolts may result in lower pressure retention capabilities, lower bend load capabilities, joint leakage and pipe joint separation.** Pipe joint separation may result in significant property damage and serious injury.

ANSI SPECIFIED BOLT TORQUE		
Bolt Size	Wrench Size	Specified Bolt Torque *
In.	In.	Ft.-Lbs
3/8	11/16	30-45
1/2	7/8	80-100
5/8	1 1/16	100-130
3/4	1 1/4	130-180
7/8	1 1/16	180-220
1	1 5/8	200-250
1 1/8	1 13/16	225-275
1 1/4	2	250-300

\* Non-lubricated bolt torques

METRIC SPECIFIED BOLT TORQUE		
Bolt Size	Wrench Size	Specified Bolt Torque *
mm	mm	N-M
M10	16	40-60
M12	22	110-150
M16	24	135-175
M20	30	175-245
M22	34	245-300
M24	36	270-340

\* Non-lubricated bolt torques

**TECHNICAL INFORMATION TABLE OF CONTENTS**

List Of Abbreviations .....	205-206	Pipe & Water Weight/Foot .....	225
Decimal Equivalents Of Fractions .....	207	Boiling Points Of Water At Various Pressures .....	226
Decimal Degree Equivalents Of Minutes .....	207	Weight/Foot - Seamless Brass & Copper Pipe .....	226
Commercial Pipe Sizes & Wall Thicknesses .....	208-209	Water Pressure To Feet Head .....	227
Standard Pipe Data .....	210	Feet Head To Water Pressure .....	227
Barlow's Formula .....	210	Flow Conversion Chart .....	228-229
Weld Fitting 90° Elbow, 180° Return, 45° Elbow .....	211	Heat Losses From Horizontal Bare Steel Pipe .....	230
Weld Fitting Tee, Cap, Cross, Stub End .....	212	Total Thermal Expansion of Piping Material .....	230
Weld Fitting Reducers & Reducing Outlet Tees .....	213	Colors And Approximate Temperature For Carbon Steel .....	230
Weld Fitting Welding Neck Flanges .....	214	Weights of Metals .....	230
Slip-on, Threaded and Socket Flanges .....	215	Specific Gravity Of Gases .....	231
Standard Cast Iron Companion Flanges & Bolts .....	215	Specific Gravity Of Liquids .....	231
Lap Joint Flanges .....	216	Typical BTU Values Of Fuels .....	231
Extra Heavy Cast Iron Companion Flanges & Bolts .....	217	Melting Points of Metals .....	232
Blind Flanges .....	217	Useful Definitions .....	233-234
Bolting Dimensions for 150 to 300 Lb. Steel Flange .....	218	Unit Conversions .....	235
Bolting Dimensions for 400 Lb./600Lb. Steel Flange .....	219	Geometry Formulas .....	236
ASTM Carbon Steel Pipe & Flange Specifications .....	220-221	Sprinkler System Formulas .....	237
How to Cut Odd-Angle Elbows .....	222	Standard Conversions .....	238
Alignment of Pipe .....	223-224	Hardness Conversion Numbers .....	239
Drill Sizes For NPT Pipe Taps .....	225	Coated Arc Welding Electrodes - Types & Styles .....	240
Tap & Drill Sizes .....	225	Physical Properties of E60 & E70 Series Electrodes .....	240

## TECHNICAL INFORMATION TABLE OF CONTENTS, CONT'D.

Trouble Shooting Arc Welding Equipment.....	241-242	A Typical Pipe Hanger Specification .....	291-295
Basic Arc & Gas Welding Symbols .....	244-245	Thermal Expansion of Pipe Material .....	296-297
Symbols For Pipe Fittings .....	246-250	Beam Dimensions .....	298-300
Wire Rope .....	251-253	Maximum Recommended Applied Torques .....	300
Gruvlok® Lubricants .....	254-255	Steel Pipe Data .....	301
Design Factors.....	257	Copper Tube Data.....	302
Gruvlok® Flow Control Components.....	258-259	Other Pipe Data.....	303
Gruvlok® Gasket Styles .....	260-261	PVC Pipe Support Spacing.....	304-305
Vacume Service.....	261	CPVC Pipe Support Spacing .....	306
Gasket Grade Index & Gasket Recommendations.....	262-263	Anvil Design Services .....	307-308
Coupling Chart Data Notes .....	264	Alphabetical Index.....	309-311
Movement—Applications .....	265-268	Figure Number Index.....	312-314
Coupling Flexibility .....	269-272	Product Listings and Approvals .....	315
Pipe Preparation .....	273-275		
Roll Groove Specifications .....	276-279		
Cut Groove Specifications.....	280-283		
Pipe Support .....	284-290		

**LIST OF ABBREVIATIONS**

Abbreviations conform to the practice of the American Standard Abbreviations for Scientific and Engineering Terms, ASA Z10.1

abs.	Absolute	cfs	Cubic feet per second
AGA	American Gas Association	Cl.	Cast Iron
AISI	American Iron and Steel Institute	CS	Cast Steel
Amer Std	American Standard	Comp.	Companion
API	American Petroleum Institute	C to F	Center to Face
ASA	American Standards Association	°C	Degrees Centigrade
Ashve	American Society of Heating and Ventilation Engineers	°F	Degrees Fahrenheit
ASME	American Society of Mechanical Engineers	diam.	Diameter
ASTM	American Society for Testing Materials	dwg.	Drawing
AWWA	American Water Works Association	ex-hy	Extra-heavy
B & S	Bell and Spigot or Brown & Sharpe (gauge)	F & D	Faced and Drilled
bbl	Barrel	F	Fahrenheit
Btu	British thermal unit(s)	F to F	Face to Face
C	Centigrade	flg.	Flange or Flanges
cfm	Cubic feet per minute	flgd.	Flanged
		g.	Gage or Gauge
		hex.	Hexagonal
		hg.	Mercury

## LIST OF ABBREVIATIONS

IBBM .....	Iron Body Bronze (or Brass) Mounted	SF.....	Semifinished
ID.....	Inside Diameter	Spec.....	Specification
kw.....	Kilowatt(s)	SSP.....	Steam Service Pressure
MI .....	Malleable Iron	SSU .....	Seconds Saybolt Universal
max.....	Maximum	Std .....	Standard
min.....	Minimum	Trans .....	Transactions
mtd .....	Mounted	WOG.....	Water, Oil, Gas (see OWG)
MSS.....	Manufacturers Standardization Society (of Valve and Fittings Industry)	WWP.....	Working Water Pressure
NEWWA .....	New England Water Works Association	XS .....	Extra Strong
NPS .....	Nominal pipe size (formerly IPS for iron pipe size)	XXS .....	Double Extra Strong
OD.....	Outside diameter		
OS&Y.....	Outside Screw and Yoke		
OWG.....	Oil, Water, Gas (see WOG)		
psig .....	Pounds per square inch, gage		
red.....	Reducing		
Sch or Sched .....	Schedule		
scd.....	Screwed		

**DECIMAL EQUIVALENTS OF FRACTIONS****DECIMAL DEGREE EQUIVALENTS OF MINUTES**

$\frac{1}{64}$ .....0.015625	$\frac{23}{64}$ .....0.359375	$\frac{45}{64}$ .....0.703125	Min	Degree	Min	Degree	Min	Degree
$\frac{1}{32}$ .....0.03125	$\frac{3}{8}$ ....0.375	$\frac{23}{32}$ .....0.71875	1	.....0.0167	21	.....0.3500	41	.....0.6833
$\frac{3}{64}$ .....0.046875	$\frac{25}{64}$ .....0.390625	$\frac{47}{64}$ .....0.734375	2	.....0.0333	22	.....0.3667	42	.....0.7000
$\frac{1}{16}$ .....0.0625	$\frac{13}{32}$ .....0.40625	$\frac{3}{4}$ ....0.75	3	.....0.0500	23	.....0.3833	43	.....0.7167
$\frac{5}{64}$ .....0.078125	$\frac{27}{64}$ .....0.421875	$\frac{49}{64}$ .....0.765625	4	.....0.0667	24	.....0.4000	44	.....0.7333
$\frac{3}{32}$ .....0.09375	$\frac{7}{16}$ .....0.4375	$\frac{25}{32}$ .....0.78125	5	.....0.0833	25	.....0.4167	45	.....0.7500
$\frac{7}{64}$ .....0.109375	$\frac{29}{64}$ .....0.453125	$\frac{51}{64}$ .....0.796875	6	.....0.1000	26	.....0.4333	46	.....0.7667
$\frac{1}{8}$ ...0.125	$\frac{15}{32}$ .....0.46875	$\frac{13}{16}$ ....0.8125	7	.....0.1167	27	.....0.4500	47	.....0.7833
$\frac{9}{64}$ .....0.140625	$\frac{31}{64}$ .....0.484375	$\frac{53}{64}$ .....0.828125	8	.....0.1333	28	.....0.4667	48	.....0.8000
$\frac{5}{32}$ .....0.15625	$\frac{1}{2}$ .....0.5	$\frac{27}{32}$ .....0.84375	9	.....0.1500	29	.....0.4833	49	.....0.8167
$\frac{11}{64}$ .....0.171875	$\frac{33}{64}$ .....0.515625	$\frac{55}{64}$ .....0.859375	10	.....0.1667	30	.....0.5000	50	.....0.8333
$\frac{3}{16}$ .....0.1875	$\frac{17}{32}$ .....0.53125	$\frac{7}{8}$ ...0.875	11	.....0.1833	31	.....0.5167	51	.....0.8500
$\frac{13}{64}$ .....0.203125	$\frac{35}{64}$ .....0.546875	$\frac{57}{64}$ .....0.890625	12	.....0.2000	32	.....0.5333	52	.....0.8667
$\frac{7}{32}$ .....0.21875	$\frac{9}{16}$ .....0.5625	$\frac{29}{32}$ .....0.90625	13	.....0.2167	33	.....0.5500	53	.....0.8833
$\frac{15}{64}$ .....0.234375	$\frac{37}{64}$ .....0.578125	$\frac{59}{64}$ .....0.921875	14	.....0.2333	34	.....0.5667	54	.....0.9000
$\frac{1}{4}$ ....0.25	$\frac{19}{32}$ .....0.59375	$\frac{15}{16}$ ....0.9375	15	.....0.2500	35	.....0.5833	55	.....0.9167
$\frac{17}{64}$ .....0.265625	$\frac{39}{64}$ .....0.609375	$\frac{61}{64}$ .....0.953125	16	.....0.2667	36	.....0.6000	56	.....0.9333
$\frac{9}{32}$ .....0.28125	$\frac{5}{8}$ ...0.625	$\frac{31}{32}$ .....0.96875	17	.....0.2833	37	.....0.6167	57	.....0.9500
$\frac{19}{64}$ .....0.296875	$\frac{41}{64}$ .....0.640625	$\frac{63}{64}$ .....0.984375	18	.....0.3000	38	.....0.6333	58	.....0.9667
$\frac{5}{16}$ .....0.3125	$\frac{21}{32}$ .....0.65625	1 .....1	19	.....0.3167	39	.....0.6500	59	.....0.9833
$\frac{21}{64}$ .....0.328125	$\frac{43}{64}$ .....0.671875		20	.....0.3333	40	.....0.6667	60	.....1.0000
$\frac{11}{32}$ .....0.34375	$\frac{11}{16}$ ....0.6875							

## COMMERCIAL PIPE SIZES AND WALL THICKNESSES

This table lists standard pipe sizes and wall thicknesses, or specifically:

1. Traditional standard weight, extra strong & durable extra strong pipe.
2. Pipe wall thickness in ASME B36.10 for carbon steel.
3. Pipe wall thickness in ASTM Specification A409 & ASME B36.19 & applicable only to corrosion resistant materials.

**NOTE:** All dimensions in inches & thicknesses are nominal or average wall thickness. Actual thickness may be as much as 12.5% under nominal due to mill tolerance.

Nom. Pipe Size	NOMINAL WALL THICKNESS FOR																	
	Outside Dia. (IN)	Sch 5S	Sch 10	Sch 10S	Sch 20	Sch 30	Sch Std.	Sch 40	Sch 40S	Sch 60	Sch 80	Sch 80S	Sch 100	Sch 120	Sch. 140	Sch. 160	X Strong	XX Strong
1/8	0.405	-	0.049	0.049	-	-	0.068	0.068	0.068	-	0.095	0.095	-	-	-	-	0.095	-
1/4	0.540	-	0.065	0.065	-	-	0.088	0.088	0.088	-	0.119	0.119	-	-	-	-	0.119	-
3/8	0.675	-	0.065	0.065	-	-	0.091	0.091	0.091	-	0.126	0.126	-	-	-	-	0.126	-
1/2	0.840	0.065	0.083	0.083	-	-	0.109	0.109	0.109	-	0.147	0.147	-	-	-	0.187	0.147	0.294
3/4	1.050	0.065	0.083	0.083	-	-	0.113	0.113	0.113	-	0.154	0.154	-	-	-	0.219	0.154	0.308
1	1.315	0.065	0.109	0.109	-	-	0.133	0.133	0.133	-	0.179	0.179	-	-	-	0.250	0.179	0.358
1 1/4	1.660	0.065	0.109	0.109	-	-	0.140	0.140	0.140	-	0.191	0.191	-	-	-	0.250	0.191	0.382
1 1/2	1.900	0.065	0.109	0.109	-	-	0.145	0.145	0.145	-	0.200	0.200	-	-	-	0.281	0.200	0.400
2	2.375	0.065	0.109	0.109	-	-	0.154	0.154	0.154	-	0.218	0.218	-	-	-	0.344	0.218	0.436
2 1/2	2.875	0.083	0.120	0.120	-	-	0.203	0.203	0.203	-	0.276	0.276	-	-	-	0.375	0.276	0.552
3	3.500	0.083	0.120	0.120	-	-	0.216	0.216	0.216	-	0.300	0.300	-	-	-	0.437	0.300	0.600
3 1/2	4.000	0.083	0.120	0.120	-	-	0.226	0.226	0.226	-	0.318	0.318	-	-	-	-	0.318	0.636
4	4.500	0.083	0.120	0.120	-	-	0.237	0.237	0.237	-	0.337	0.337	-	0.438	-	0.531	0.337	0.674
5	5.563	0.109	0.134	0.134	-	-	0.258	0.258	0.258	-	0.375	0.375	-	0.500	-	0.625	0.375	0.750

## COMMERCIAL PIPE SIZES AND WALL THICKNESSES

Nom.	NOMINAL WALL THICKNESS FOR																	
	Pipe Size	Outside Dia. (IN)	Sch. 5S	Sch. 10	Sch. 10S	Sch. 20	Sch. 30	Sch. Std.	Sch. 40	Sch. 40S	Sch. 60	Sch. 80	Sch. 80S	Sch. 100	Sch. 120	Sch. 140	Sch. 160	X Strong
6	6.625	0.109	0.134	0.134	-	-	0.280	0.280	0.280	-	0.432	0.432	-	0.562	-	0.719	0.432	0.864
8	8.625	0.109	0.148	0.148	0.250	0.277	0.322	0.322	0.322	0.406	0.500	0.500	0.594	0.719	0.812	0.906	0.500	0.875
10	10.750	0.134	0.165	0.165	0.250	0.307	0.365	0.365	0.365	0.500	0.594	0.500	0.719	0.844	1.000	1.125	0.500	1.000
12	12.750	0.156	0.180	0.180	0.250	0.330	0.375	0.406	0.375	0.562	0.688	0.500	0.844	1.000	1.125	1.312	0.500	1.000
14	14.000	0.156	0.250	0.188	0.312	0.375	0.375	0.438	-	0.594	0.750	-	0.938	1.094	1.250	1.406	0.500	-
16	16.000	0.165	0.250	0.188	0.312	0.375	0.375	0.500	-	0.656	0.844	-	1.031	1.219	1.438	1.594	0.500	-
18	18.000	0.165	0.250	0.188	0.312	0.438	0.375	0.562	-	0.750	0.938	-	1.156	1.375	1.562	1.781	0.500	-
20	20.000	0.188	0.250	0.218	0.375	0.500	0.375	0.594	-	0.812	1.031	-	1.281	1.500	1.750	1.969	0.500	-
22	22.000	0.188	0.250	0.218	0.375	0.500	0.375	-	-	0.875	1.125	-	1.375	1.625	1.875	2.125	0.500	-
24	24.000	0.218	0.250	-	0.375	0.562	0.375	0.688	-	0.969	1.219	-	1.531	1.812	2.062	2.344	0.500	-
26	26.000	-	0.312	-	0.500	-	0.375	-	-	-	-	-	-	-	-	-	0.500	-
28	28.000	-	0.312	-	0.500	0.625	0.375	-	-	-	-	-	-	-	-	-	0.500	-
30	30.000	0.250	0.312	0.312	0.500	0.625	0.375	-	-	-	-	-	-	-	-	-	0.500	-
32	32.000	-	0.312	-	0.500	0.625	0.375	0.688	-	-	-	-	-	-	-	-	0.500	-
34	34.000	-	0.312	-	0.500	0.625	0.375	0.688	-	-	-	-	-	-	-	-	0.500	-
36	36.000	-	0.312	-	0.500	0.625	0.375	0.750	-	-	-	-	-	-	-	-	0.500	-
42	42.000	-	-	-	0.500	0.625	0.375	0.750	-	-	-	-	-	-	-	-	0.500	-

All dimensions shown are in inches.

## STANDARD WEIGHT PIPE DATA

Nom. Pipe Dia. (Inches)	Nom. Inside Dia. (Inches)	Nom. Outside Dia. (Inches)	Nom. Wt./Ft. (Pounds)	Length Containing One Cu. Ft. (Feet)	Gallons per Linear Ft. (Gallons)
1/8	0.269	0.405	0.245	2,526.000	0.0030
1/4	0.364	0.540	0.425	1,383.800	0.0054
3/8	0.493	0.675	0.568	754.360	0.0099
1/2	0.622	0.840	0.851	473.910	0.0158
3/4	0.824	1.050	1.131	270.030	0.0277
1	1.049	1.315	1.679	166.620	0.0449
1 1/4	1.380	1.660	2.273	96.275	0.0777
1 1/2	1.610	1.900	2.718	70.733	0.1058
2	2.067	2.375	3.653	49.913	0.1743
2 1/2	2.469	2.875	5.793	30.077	0.2487
3	3.068	3.500	7.580	19.479	0.3840
3 1/2	3.548	4.000	9.110	14.565	0.5136
4	4.026	4.500	10.790	11.312	0.6613
5	5.047	5.563	14.620	7.198	1.0393
6	6.065	6.625	18.970	4.984	1.5008
8	7.981	8.625	28.550	2.878	2.5988
10	10.020	10.750	40.480	1.826	4.0963

## BARLOW'S FORMULA

Barlow's Formula is a safe, easy method for finding the relationship between internal fluid pressure and stress in the pipe wall. The formula predicts bursting pressures that have been found to be safely within the actual test bursting pressures.

It is interesting to note that the formula uses the "outside diameter" of pipe and is sometimes referred to as the "outside diameter formula."

$$P = (2 \cdot t \cdot S) / D$$

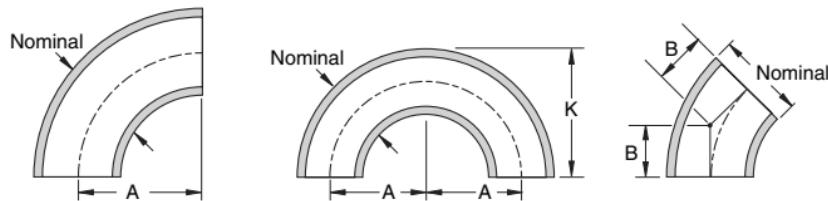
Where:

P = internal units pressure, in psi

S = unit stress, in psi

D = outside diameter of pipe, in inches

t = wall thickness, in inches

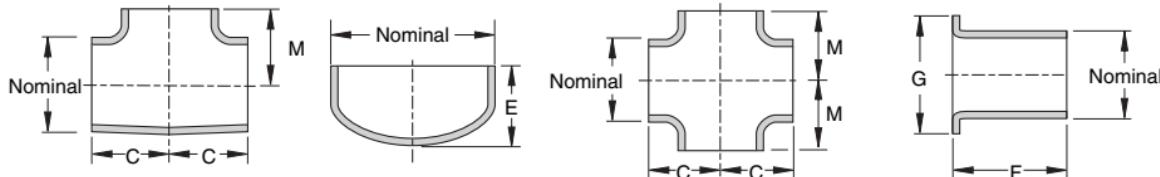
**WELD FITTING—90° ELBOW, 180° RETURN, 45° ELBOW**

Nom. Pipe Size	90° ELBOWS		180° RETURNS		45° LR Elbow B
	Long R A	Short R A	Long R K	Short R K	
1/2	1 1/2	—	1 7/8	—	5/8
3/4	1 1/8	—	1 11/16	—	7/16
1	1 1/2	1	2 3/16	1 5/8	7/8
1 1/4	1 7/8	1 1/4	2 3/4	2 1/16	1
1 1/2	2 1/4	1 1/2	3 1/4	2 7/16	1 1/8
2	3	2	4 3/16	3 3/16	1 3/8
2 1/2	3 3/4	2 1/2	5 3/16	3 15/16	1 3/4
3	4 1/2	3	6 1/4	4 3/4	2
3 1/2	5 1/4	3 1/2	7 1/4	5 1/2	2 1/4
4	6	4	8 1/4	6 1/4	2 1/2
5	7 1/2	5	10 5/16	7 3/4	3 1/8
6	9	6	12 5/16	9 5/16	3 3/4
8	12	8	16 5/16	12 5/16	5
10	15	10	20 3/8	15 3/8	6 1/4
12	18	12	24 3/8	18 3/8	7 1/2

Nom. Pipe Size	90° ELBOWS		180° RETURNS		45° LR Elbow B
	Long R A	Short R A	Long R K	Short R K	
14	21	14	28	21	8 3/4
16	24	16	32	24	10
18	27	18	36	27	11 1/4
20	30	20	40	30	12 1/2
22	33	22	44	—	13 1/2
24	36	24	48	36	15
26	39	26	52	—	16
30	45	30	60	45	18 1/2
34	51	34	—	—	21
36	54	36	72	54	22 1/4
42	63	48	—	—	26

All dimensions shown are in inches.

## WELD FITTING—TEE, CAP, CROSS, STUB END

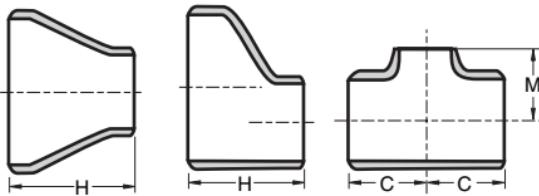


Nom. Pipe Size	Straight Tees C & M	Caps E	Straight Crosses C & M	Long Pattern Stub Ends F	G
1/2	1	1	—	3	1 <sup>3</sup> / <sub>8</sub>
3/4	1 <sup>1</sup> / <sub>8</sub>	1	—	3	1 <sup>11</sup> / <sub>16</sub>
1	1 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>	—	4	2
1 <sup>1</sup> / <sub>4</sub>	1 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>8</sub>	4	2 <sup>1</sup> / <sub>2</sub>
1 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>4</sub>	4	2 <sup>7</sup> / <sub>8</sub>
2	2 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub> *	2 <sup>1</sup> / <sub>2</sub>	6	3 <sup>5</sup> / <sub>8</sub>
2 <sup>1</sup> / <sub>2</sub>	3	1 <sup>1</sup> / <sub>2</sub> *	3	6	4 <sup>1</sup> / <sub>8</sub>
3	3 <sup>3</sup> / <sub>8</sub>	2*	3 <sup>3</sup> / <sub>8</sub>	6	5
3 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub> *	3 <sup>3</sup> / <sub>4</sub>	6	5 <sup>1</sup> / <sub>2</sub>
4	4 <sup>1</sup> / <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub> *	4 <sup>1</sup> / <sub>8</sub>	6	6 <sup>3</sup> / <sub>16</sub>
5	4 <sup>7</sup> / <sub>8</sub>	3*	4 <sup>7</sup> / <sub>8</sub>	8	7 <sup>5</sup> / <sub>16</sub>
6	5 <sup>5</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>2</sub> *	5 <sup>5</sup> / <sub>8</sub>	8	8 <sup>1</sup> / <sub>2</sub>
8	7	4*	7	8	10 <sup>5</sup> / <sub>8</sub>
10	8 <sup>1</sup> / <sub>2</sub>	5*	8 <sup>1</sup> / <sub>2</sub>	10	12 <sup>3</sup> / <sub>4</sub>
12	10	6*	10	10	15

Nom. Pipe Size	Straight Tees C & M	Caps E	Straight Crosses C & M	Long Pattern Stub Ends F	G
14	11	6 <sup>1</sup> / <sub>2</sub> *	11	12	16 <sup>1</sup> / <sub>4</sub>
16	12	7*	12	12	18 <sup>1</sup> / <sub>2</sub>
18	13 <sup>1</sup> / <sub>2</sub>	8*	13 <sup>1</sup> / <sub>2</sub>	12	21
20	15	9*	15	12	23
22	16 <sup>1</sup> / <sub>2</sub>	10	—	—	—
24	17	10 <sup>1</sup> / <sub>2</sub>	17	12	27 <sup>1</sup> / <sub>4</sub>
26	19 <sup>1</sup> / <sub>2</sub>	10 <sup>1</sup> / <sub>2</sub>	—	—	—
30	22	10 <sup>1</sup> / <sub>2</sub>	—	—	—
34	25	10 <sup>1</sup> / <sub>2</sub>	—	—	—
36	26 <sup>1</sup> / <sub>2</sub>	10 <sup>1</sup> / <sub>2</sub>	—	—	—
42	C=30,M=28	12	—	—	—

\*Dimensions apply to STD and XS only.  
All dimensions shown are in inches.

## WELD FITTING—REDUCERS AND REDUCING OUTLET TEES



**H:** Concentric & Eccentric Reducers   **C, M:** Reducing Outlet Tees

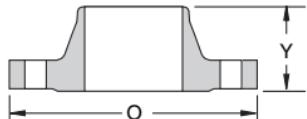
Nom. Pipe Size	H	C	M
1/2 x 1/4	—	1	1
3/8	—	1	1
3/4 x 3/8	1 1/2	1 1/8	1 1/8
1/2	1 1/2	1 1/8	1 1/8
1 x 3/8	2	1 1/2	1 1/2
1/2	2	1 1/2	1 1/2
3/4	2	1 1/2	1 1/2
1 1/4 x 1/2	2	1 7/8	1 7/8
3/4	2	1 7/8	1 7/8
1	2	1 7/8	1 7/8
1 1/2 x 1/2	2 1/2	2 1/4	2 1/4
3/4	2 1/2	2 1/4	2 1/4
1	2 1/2	2 1/4	2 1/4
1 1/4	2 1/2	2 1/4	2 1/4
2 x 3/4	3	2 1/2	1 3/4
1	3	2 1/2	2
1 1/4	3	2 1/2	2 1/4
1 1/2	3	2 1/2	2 3/8

Nom. Pipe Size	H	C	M
2 1/2 x 1	3 1/2	3	2 1/4
1 1/4	3 1/2	3	2 1/2
1 1/2	3 1/2	3	2 5/8
2	3 1/2	3	2 3/4
3 x 1	—	3 3/8	2 5/8
1 1/4	3 1/2	3 3/8	2 3/4
1 1/2	3 1/2	3 3/8	2 7/8
2	3 1/2	3 3/8	3
2 1/2	3 1/2	3 3/8	3 1/4
3 1/2 x 1 1/4	4	—	—
1 1/2	4	3 3/4	3 1/8
2	4	3 3/4	3 1/4
2 1/2	4	3 3/4	3 1/2
3	4	3 3/4	3 5/8
4 x 1 1/2	4	4 1/8	3 3/8
2	4	4 1/8	3 1/2
2 1/2	4	4 1/8	3 3/4
3	4	4 1/8	3 7/8
3 1/2	4	4 1/8	4

Nom. Pipe Size	H	C	M
5 x 2	5	4 7/8	4 1/8
2 1/2	5	4 7/8	4 1/4
3	5	4 7/8	4 3/8
3 1/2	5	4 7/8	4 1/2
4	5	4 7/8	4 5/8
6 x 2 1/2	5 1/2	5 5/8	4 3/4
3	5 1/2	5 5/8	4 7/8
3 1/2	5 1/2	5 5/8	5
4	5 1/2	5 5/8	5 1/8
5	5 1/2	5 5/8	5 3/8
8 x 3	—	7	6
3 1/2	6	7	6
4	6	7	6 1/8
5	6	7	6 3/8
6	6	7	6 5/8
10 x 4	7	8 1/2	7 1/4
5	7	8 1/2	7 1/2
6	7	8 1/2	7 5/8
8	7	8 1/2	8
12 x 5	8	10	8 1/2
6	8	10	8 5/8
8	8	10	9
10	8	10	9 1/2
14 x 6	13	11	9 3/8
8	13	11	9 3/4
10	13	11	10 1/8
12	13	11	10 5/8

All dimensions shown are in inches.

## WELD FITTING—WELDING NECK FLANGES



Nom. Pipe Size	150 LB.		300 LB.		400 LB.		600 LB.	
	O	Y <sup>(1)</sup>	O	Y <sup>(1)</sup>	O	Y <sup>(2)</sup>	O	Y <sup>(2)</sup>
1/2	3 1/2	1 7/8	3 3/4	2 1/16	3 3/4	2 1/16	3 3/4	2 1/16
3/4	3 7/8	2 1/16	4 5/8	2 1/4	4 5/8	2 1/4	4 5/8	2 1/4
1	4 1/4	2 3/16	4 7/8	2 7/16	4 7/8	2 7/16	4 7/8	2 7/16
1 1/4	4 5/8	2 1/4	5 1/4	2 9/16	5 1/4	2 5/8	5 1/4	2 5/8
1 1/2	5	2 7/16	6 1/8	2 11/16	6 1/8	2 3/4	6 1/8	2 3/4
2	6	2 1/2	6 1/2	2 3/4	6 1/2	2 7/8	6 1/2	2 7/8
2 1/2	7	2 3/4	7 1/2	3	7 1/2	3 1/8	7 1/2	3 1/8
3	7 1/2	2 3/4	8 1/4	3 1/8	8 1/4	3 1/4	8 1/4	3 1/4
3 1/2	8 1/2	2 13/16	9	3 3/16	9	3 3/8	9	3 3/8
4	9	3	10	3 3/8	10	3 1/2	10 3/4	4
5	10	3 1/2	11	3 7/8	11	4	13	4 1/2
6	11	3 1/2	12 1/2	3 7/8	12 1/2	4 1/16	14	4 5/8
8	13 1/2	4	15	4 3/8	15	4 5/8	16 1/2	5 1/4
10	16	4	17 1/2	4 5/8	17 1/2	4 7/8	20	6
12	19	4 1/2	20 1/2	5 1/8	20 1/2	5 3/8	22	6 1/8

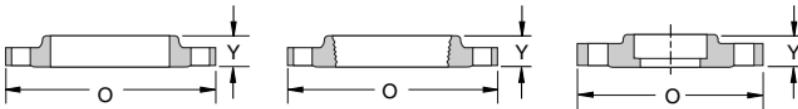
Nom. Pipe Size	150 LB.		300 LB.		400 LB.		600 LB.	
	O	Y <sup>(1)</sup>	O	Y <sup>(1)</sup>	O	Y <sup>(2)</sup>	O	Y <sup>(2)</sup>
14	21	5	23	5 5/8	23	5 7/8	23 3/4	6 1/2
16	23 1/2	5	25 1/2	5 3/4	25 1/2	6	27	7
18	25	5 1/2	28	6 1/4	28	6 1/2	29 1/4	7 1/4
20	27 1/2	5 11/16	30 1/2	6 3/8	30 1/2	6 5/8	32	7 1/2
22	29 1/2	5 7/8	33	6 1/2	33	6 3/4	34 1/4	7 3/4
24	32	6	36	6 5/8	36	6 7/8	37	8
26	34 1/4	5	38 1/4	7 1/4	38 1/4	7 5/8	40	8 3/4
30	38 3/4	5 1/8	43	8 1/4	43	8 5/8	44 1/2	9 3/4
34	43 3/4	5 5/16	47 1/2	9 1/8	47 1/2	9 1/2	49	10 5/8
36	46	5 3/8	50	9 1/2	50	9 7/8	51 3/4	11 1/8
42	53	5 5/8	50 3/4	7 7/8	52	8 13/16	55 1/4	11

(1) The 1/16" raised face is included in length thru Hub, "Y".

(2) The 1/4" raised face is not included in length thru Hub, "Y".

All dimensions shown are in inches.

## SLIP-ON, THREADED AND SOCKET FLANGES



Nom. Pipe Size	150 LB.		300 LB.		400 LB.†		600 LB.	
	O	Y <sup>(1)</sup>	O	Y <sup>(1)</sup>	O	Y <sup>(2)</sup>	O	Y <sup>(2)</sup>
1/2	3 1/2	5/8	3 3/4	7/8	3 3/4	7/8	3 3/4	7/8
3/4	3 7/8	5/8	4 5/8	1	4 5/8	1	4 5/8	1
1	4 1/4	11/16	4 7/8	1 1/16	4 7/8	1 1/16	4 7/8	1 1/16
1 1/4	4 5/8	13/16	5 1/4	1 1/16	5 1/4	1 1/8	5 1/4	1 1/8
1 1/2	5	7/8	6 1/8	1 3/16	6 1/8	1 1/4	6 1/8	1 1/4
2	6	1	6 1/2	1 5/16	6 1/2	1 7/16	6 1/2	1 7/16
2 1/2	7	1 1/8	7 1/2	1 1/2	7 1/2	1 5/8	7 1/2	1 5/8
3	7 1/2	1 3/16	8 1/4	1 11/16	8 1/4	1 13/16	8 1/4	1 13/16
3 1/2	8 1/2	1 1/4†	9	1 3/4†	9	1 15/16	9	1 15/16†
4	9	1 5/16†	10	1 7/8†	10	2	10 3/4	2 1/8†
5	10	1 7/16†	11	2†	11	2 1/8	13	2 3/8*†
6	11	1 9/16†	12 1/2	2 1/16†	12 1/2	2 1/4	14	2 5/8†
8	13 1/2	1 3/4†	15	2 7/16†	15	2 11/16	16 1/2	3†
10	16	1 15/16†	17 1/2	2 5/8†	17 1/2	2 7/8	20	3 3/8†
12	19	2 3/16†	20 1/2	2 7/8†	20 1/2	3 1/8	22	3 5/8†
14	21	2 1/4†	23	3†	23	3 5/16	23 3/4	3 11/16†
16	23 1/2	2 1/2†	25 1/2	3 1/4†	25 1/2	3 11/16	27	4 3/16†
18	25	2 11/16†	28	3 1/2†	28	3 7/8	29 1/4	4 5/8†

Nom. Pipe Size	150 LB.		300 LB.		400 LB.†		600 LB.	
	O	Y <sup>(1)</sup>	O	Y <sup>(1)</sup>	O	Y <sup>(2)</sup>	O	Y <sup>(2)</sup>
20	27 1/2	2 7/8†	30 1/2	3 3/4†	30 1/2	4	32	5†
22	29 1/2	3 1/8 *†	33	4 *†	33	4 1/4 *	34 1/4	5 1/4 *†
24	32	3 1/4†	36	4 3/16†	36	4 1/2	37	5 1/2†
26	34 1/4	3 3/8 *†	38 1/4	7 1/4 *†	38 1/4	7 5/8 *	40	8 3/4 *†
30	38 3/4	3 1/2 *†	43	8 1/4 *†	43	8 5/8 *	44 1/2	9 3/4 *†
34	43 3/4	3 11/16 *†	47 1/2	9 1/8 *†	47 1/2	9 1/2 *	49	10 5/8 *†
36	46	3 3/4 *†	50	9 1/2 *†	50	9 7/8 *	51 3/4	11 1/8 *†
42	53	4 *†	-	-	-	-	-	-

\* Not available in Threaded type

† Not available in Socket type

(1) The 1/16" raised face is included in length thru Hub, "Y".

(2) The 1/4" raised face is not included in length thru Hub, "Y".

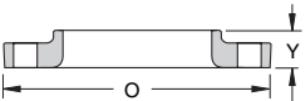
All dimensions shown are in inches.

**STANDARD CAST IRON COMPANION FLANGES & BOLTS**

(for working pressures up to 125 psi steam, 175 psi WOG)

Size	Flange Dia.	Bolt Circle	No. Bolts	Bolt Size	Bolt Length
3/4	3 1/2	2 1/2	4	3/8	1 3/8
1	4 1/4	3 1/8	4	1/2	1 1/2
1 1/4	4 5/8	3 1/2	4	1/2	1 1/2
1 1/2	5	3 7/8	4	1/2	1 3/4
2	6	4 3/4	4	5/8	2
2 1/2	7	5 1/2	4	5/8	2 1/4
3	7 1/2	6	4	5/8	2 1/2
3 1/2	8 1/2	7	8	5/8	2 1/2
4	9	7 1/2	8	5/8	2 3/4
5	10	8 1/2	8	3/4	3
6	11	9 1/2	8	3/4	3
8	13 1/2	11 3/4	8	3/4	3 1/4
10	16	14 1/4	12	7/8	3 1/2
12	19	17	12	7/8	3 3/4
14	21	18 3/4	12	1	4 1/4
16	23 1/2	21 1/4	16	1	4 1/4

All dimensions shown are in inches.

**LAP JOINT FLANGES**

Nom. Pipe Size	150 LB.		300 LB.		400 LB.		600 LB.	
	O	Y	O	Y	O	Y	O	Y
1/2	3 1/2	5/8	3 3/4	7/8	3 3/4	7/8	3 3/4	7/8
3/4	3 7/8	5/8	4 5/8	1	4 5/8	1	4 5/8	1
1	4 1/4	11/16	4 7/8	1 1/16	4 7/8	1 1/16	4 7/8	1 1/16
1 1/4	4 5/8	13/16	5 1/4	1 1/16	5 1/4	1 1/8	5 1/4	1 1/8
1 1/2	5	7/8	6 1/8	1 3/16	6 1/8	1 1/4	6 1/8	1 1/4
2	6	1	6 1/2	1 5/16	6 1/2	1 7/16	6 1/2	1 7/16
2 1/2	7	1 1/8	7 1/2	1 1/2	7 1/2	1 5/8	7 1/2	1 5/8
3	7 1/2	1 3/16	8 1/4	1 11/16	8 1/4	1 13/16	8 1/4	1 13/16
3 1/2	8 1/2	1 1/4	9	1 3/4	9	1 15/16	9	1 15/16
4	9	1 5/16	10	1 7/8	10	2	10 3/4	2 1/8
5	10	1 7/16	11	2	11	2 1/8	13	2 3/8
6	11	1 9/16	12 1/2	2 1/16	12 1/2	2 1/4	14	2 5/8
8	13 1/2	1 3/4	15	2 7/16	15	2 11/16	16 1/2	3
10	16	1 15/16	17 1/2	3 3/4	17 1/2	4	20	4 3/8
12	19	2 3/16	20 1/2	4	20 1/2	4 1/4	22	4 5/8
14	21	3 1/8	23	4 3/8	23	4 5/8	23 3/4	5
16	23 1/2	3 7/16	25 1/2	4 3/4	25 1/2	5	27	5 1/2
18	25	3 13/16	28	5 1/8	28	5 3/8	29 1/4	6
20	27 1/2	4 1/16	30 1/2	5 1/2	30 1/2	5 3/4	32	6 1/2
24	32	4 3/8	36	6	36	6 1/4	37	7 1/4

All dimensions shown are in inches.

## EXTRA HEAVY CAST IRON COMPANION FLANGES AND BOLTS

(for working pressures up to 250 psi steam, 400 psi WOG)

Size	Flange Dia.	Bolt Circle	No. Bolts	Bolt Size	Bolt Length
1	4 <sup>7</sup> / <sub>8</sub>	3 <sup>1</sup> / <sub>2</sub>	4	5/ <sub>8</sub>	2 <sup>1</sup> / <sub>4</sub>
1 <sup>1</sup> / <sub>4</sub>	5 <sup>1</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	4	5/ <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>
1 <sup>1</sup> / <sub>2</sub>	6 <sup>1</sup> / <sub>8</sub>	4 <sup>1</sup> / <sub>2</sub>	4	3/ <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>
2	6 <sup>1</sup> / <sub>2</sub>	5	8	5/ <sub>8</sub>	2 <sup>1</sup> / <sub>2</sub>
2 <sup>1</sup> / <sub>2</sub>	7 <sup>1</sup> / <sub>2</sub>	5 <sup>7</sup> / <sub>8</sub>	8	3/ <sub>4</sub>	3
3	8 <sup>1</sup> / <sub>4</sub>	6 <sup>5</sup> / <sub>8</sub>	8	3/ <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>
3 <sup>1</sup> / <sub>2</sub>	9	7 <sup>1</sup> / <sub>4</sub>	8	3/ <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>
4	10	7 <sup>7</sup> / <sub>8</sub>	8	3/ <sub>4</sub>	3 <sup>1</sup> / <sub>2</sub>
5	11	9 <sup>1</sup> / <sub>4</sub>	8	3/ <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>
6	12 <sup>1</sup> / <sub>2</sub>	10 <sup>5</sup> / <sub>8</sub>	12	3/ <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>
8	15	13	12	7/ <sub>8</sub>	4 <sup>1</sup> / <sub>4</sub>
10	17 <sup>1</sup> / <sub>2</sub>	15 <sup>1</sup> / <sub>4</sub>	16	1	5
12	20 <sup>1</sup> / <sub>2</sub>	17 <sup>3</sup> / <sub>4</sub>	16	1 <sup>1</sup> / <sub>8</sub>	5 <sup>1</sup> / <sub>2</sub>
14 O.D.	23	20 <sup>1</sup> / <sub>4</sub>	20	1 <sup>1</sup> / <sub>8</sub>	5 <sup>3</sup> / <sub>4</sub>
16 O.D.	25 <sup>1</sup> / <sub>2</sub>	22 <sup>1</sup> / <sub>2</sub>	20	1 <sup>1</sup> / <sub>4</sub>	6
18 O.D.	28	24 <sup>3</sup> / <sub>4</sub>	24	1 <sup>1</sup> / <sub>4</sub>	6 <sup>1</sup> / <sub>4</sub>
20 O.D.	30 <sup>1</sup> / <sub>2</sub>	27	24	1 <sup>1</sup> / <sub>4</sub>	6 <sup>3</sup> / <sub>4</sub>
24 O.D.	36	32	24	1 <sup>1</sup> / <sub>2</sub>	7 <sup>1</sup> / <sub>2</sub>
30 O.D.	43	39 <sup>1</sup> / <sub>4</sub>	28	1 <sup>3</sup> / <sub>4</sub>	8 <sup>1</sup> / <sub>2</sub>
36 O.D.	50	46	32	2	9 <sup>1</sup> / <sub>2</sub>
42 O.D.	57	52 <sup>3</sup> / <sub>4</sub>	36	2	10
48 O.D.	65	60 <sup>3</sup> / <sub>4</sub>	40	2	11

## BLIND FLANGES



Nom. Pipe Size	150 LB.		300 LB.		400 LB.		600 LB.	
	O	Y <sup>(1)</sup>	O	Y <sup>(1)</sup>	O	Y <sup>(2)</sup>	O	Y <sup>(2)</sup>
1/2	3 <sup>1</sup> / <sub>2</sub>	7/ <sub>16</sub>	3 <sup>3</sup> / <sub>4</sub>	9/ <sub>16</sub>	For sizes	3 <sup>3</sup> / <sub>4</sub>	9/ <sub>16</sub>	
3/4	3 <sup>7</sup> / <sub>8</sub>	1/2	4 <sup>5</sup> / <sub>8</sub>	5/ <sub>8</sub>		4 <sup>5</sup> / <sub>8</sub>	5/ <sub>8</sub>	
1	4 <sup>1</sup> / <sub>4</sub>	9/ <sub>16</sub>	4 <sup>7</sup> / <sub>8</sub>	1 <sup>1</sup> / <sub>16</sub>	3 <sup>1</sup> / <sub>2</sub>	4 <sup>7</sup> / <sub>8</sub>	11/ <sub>16</sub>	
1 <sup>1</sup> / <sub>4</sub>	4 <sup>5</sup> / <sub>8</sub>	5/ <sub>8</sub>	5 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	and smaller use	5 <sup>1</sup> / <sub>4</sub>	13/ <sub>16</sub>	
1 <sup>1</sup> / <sub>2</sub>	5	1 <sup>1</sup> / <sub>16</sub>	6 <sup>1</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>16</sub>		6 <sup>1</sup> / <sub>8</sub>	7/ <sub>8</sub>	
2	6	3/ <sub>4</sub>	6 <sup>1</sup> / <sub>2</sub>	7/ <sub>8</sub>		6 <sup>1</sup> / <sub>2</sub>	1	
2 <sup>1</sup> / <sub>2</sub>	7	7/ <sub>8</sub>	7 <sup>1</sup> / <sub>2</sub>	1	600 LB.	7 <sup>1</sup> / <sub>2</sub>	11/ <sub>8</sub>	
3	7 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>16</sub>	8 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	Standard	8 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	
3 <sup>1</sup> / <sub>2</sub>	8 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>16</sub>	9	1 <sup>3</sup> / <sub>16</sub>		9	1 <sup>3</sup> / <sub>8</sub>	
4	9	1 <sup>5</sup> / <sub>16</sub>	10	1 <sup>1</sup> / <sub>4</sub>	10	1 <sup>3</sup> / <sub>8</sub>	10 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>
5	10	1 <sup>5</sup> / <sub>16</sub>	11	1 <sup>3</sup> / <sub>8</sub>	11	1 <sup>1</sup> / <sub>2</sub>	13	1 <sup>3</sup> / <sub>4</sub>
6	11	1	12 <sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>16</sub>	12 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>8</sub>	14	1 <sup>7</sup> / <sub>8</sub>
8	13 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>8</sub>	15	1 <sup>5</sup> / <sub>8</sub>	15	1 <sup>7</sup> / <sub>8</sub>	16 <sup>1</sup> / <sub>2</sub>	2 <sup>3</sup> / <sub>16</sub>
10	16	1 <sup>3</sup> / <sub>16</sub>	17 <sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>8</sub>	17 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>8</sub>	20	2 <sup>1</sup> / <sub>2</sub>
12	19	1 <sup>1</sup> / <sub>4</sub>	20 <sup>1</sup> / <sub>2</sub>	2	20 <sup>1</sup> / <sub>2</sub>	1/ <sub>4</sub>	22	2 <sup>5</sup> / <sub>8</sub>
14	21	1 <sup>3</sup> / <sub>8</sub>	23	2 <sup>1</sup> / <sub>8</sub>	23	2 <sup>3</sup> / <sub>8</sub>	23 <sup>3</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>
16	23 <sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>16</sub>	25 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>4</sub>	25 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>2</sub>	27	3
18	25	1 <sup>9</sup> / <sub>16</sub>	28	2 <sup>3</sup> / <sub>8</sub>	28	2 <sup>5</sup> / <sub>8</sub>	29 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>
20	27 <sup>1</sup> / <sub>2</sub>	1 <sup>11</sup> / <sub>16</sub>	30 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>2</sub>	30 <sup>1</sup> / <sub>2</sub>	2 <sup>3</sup> / <sub>4</sub>	32	3 <sup>1</sup> / <sub>2</sub>
22	29 <sup>1</sup> / <sub>2</sub>	1 <sup>13</sup> / <sub>16</sub>	33	2 <sup>5</sup> / <sub>8</sub>	33	2 <sup>7</sup> / <sub>8</sub>	34 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>
24	32	1 <sup>7</sup> / <sub>8</sub>	36	2 <sup>3</sup> / <sub>4</sub>	36	3	37	4
26	34 <sup>1</sup> / <sub>4</sub>	2	38 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>8</sub>	38 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>2</sub>	40	4 <sup>1</sup> / <sub>4</sub>
30	38 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>8</sub>	43	3 <sup>5</sup> / <sub>8</sub>	43	4	44 <sup>1</sup> / <sub>2</sub>	4 <sup>1</sup> / <sub>2</sub>
34	43 <sup>3</sup> / <sub>4</sub>	2 <sup>5</sup> / <sub>16</sub>	47 <sup>1</sup> / <sub>2</sub>	4	47 <sup>1</sup> / <sub>2</sub>	4 <sup>3</sup> / <sub>8</sub>	49	4 <sup>3</sup> / <sub>4</sub>
36	46	2 <sup>3</sup> / <sub>8</sub>	50	4 <sup>1</sup> / <sub>8</sub>	50	4 <sup>1</sup> / <sub>2</sub>	51 <sup>3</sup> / <sub>4</sub>	4 <sup>7</sup> / <sub>8</sub>
42	53	2 <sup>5</sup> / <sub>8</sub>	57	4 <sup>5</sup> / <sub>8</sub>	57	5 <sup>1</sup> / <sub>8</sub>	58 <sup>3</sup> / <sub>4</sub>	5 <sup>1</sup> / <sub>2</sub>

(1) The 1/16" raised face is included in Thickness, "Y".

(2) The 1/4" raised face is not included in Thickness, "Y".

## BOLTING DIMENSIONS FOR 150 TO 300 LB. STEEL FLANGE

125/150 LB. FLANGE						250/300 LB. FLANGE					
Nom. Pipe Size	Bolt Circle Dia.	Bolt Dia.	No. of Bolts	*Stud Len.	Bolt Len.	Bolt Circle Dia.	Bolt Dia.	No. of Bolts	*Stud Len.	Bolt Len.	
1/2	2 <sup>3</sup> / <sub>8</sub>	1/2	4	2 <sup>1</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>4</sub>	2 <sup>5</sup> / <sub>8</sub>	1/2	4	2 <sup>1</sup> / <sub>2</sub>	2	
3/4	2 <sup>3</sup> / <sub>8</sub>	1/2	4	2 <sup>1</sup> / <sub>4</sub>	2	3 <sup>1</sup> / <sub>4</sub>	5/8	4	2 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	
1	3 <sup>1</sup> / <sub>8</sub>	1/2	4	2 <sup>1</sup> / <sub>2</sub>	2	3 <sup>1</sup> / <sub>2</sub>	5/8	4	3	2 <sup>1</sup> / <sub>2</sub>	
1 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>2</sub>	1/2	4	2 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	5/8	4	3	2 <sup>3</sup> / <sub>4</sub>	
1 <sup>1</sup> / <sub>2</sub>	3 <sup>7</sup> / <sub>8</sub>	1/2	4	2 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>2</sub>	3/4	4	3 <sup>1</sup> / <sub>2</sub>	3	
2	4 <sup>3</sup> / <sub>8</sub>	5/8	4	3	2 <sup>3</sup> / <sub>4</sub>	5	5/8	8	3 <sup>1</sup> / <sub>4</sub>	3	
2 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>8</sub>	4	3 <sup>1</sup> / <sub>4</sub>	3	5 <sup>7</sup> / <sub>8</sub>	3/4	8	3 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>		
3	6	5/8	4	3 <sup>1</sup> / <sub>2</sub>	3	6 <sup>5</sup> / <sub>8</sub>	3/4	8	4	3 <sup>1</sup> / <sub>2</sub>	
3 <sup>1</sup> / <sub>2</sub>	7	5/8	8	3 <sup>1</sup> / <sub>2</sub>	3	7 <sup>1</sup> / <sub>4</sub>	3/4	8	4 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>	
4	7 <sup>1</sup> / <sub>2</sub>	5/8	8	3 <sup>1</sup> / <sub>2</sub>	3	7 <sup>7</sup> / <sub>8</sub>	3/4	8	4 <sup>1</sup> / <sub>4</sub>	3 <sup>3</sup> / <sub>4</sub>	
5	8 <sup>1</sup> / <sub>2</sub>	3/4	8	3 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	9 <sup>1</sup> / <sub>4</sub>	3/4	8	4 <sup>1</sup> / <sub>2</sub>	4	
6	9 <sup>1</sup> / <sub>2</sub>	3/4	8	3 <sup>3</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	10 <sup>5</sup> / <sub>8</sub>	3/4	12	4 <sup>3</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>4</sub>	
8	11 <sup>3</sup> / <sub>4</sub>	3/4	8	4	3 <sup>1</sup> / <sub>2</sub>	13	7/8	12	5 <sup>1</sup> / <sub>4</sub>	4 <sup>3</sup> / <sub>4</sub>	
10	14 <sup>1</sup> / <sub>8</sub>	7/8	12	4 <sup>1</sup> / <sub>2</sub>	3 <sup>3</sup> / <sub>4</sub>	15 <sup>1</sup> / <sub>4</sub>	1	16	6	5 <sup>1</sup> / <sub>4</sub>	
12	17	7/8	12	4 <sup>1</sup> / <sub>2</sub>	4	17 <sup>3</sup> / <sub>4</sub>	11/8	16	6 <sup>1</sup> / <sub>2</sub>	5 <sup>3</sup> / <sub>4</sub>	
14	18 <sup>3</sup> / <sub>4</sub>	1	12	5	4 <sup>1</sup> / <sub>4</sub>	20 <sup>1</sup> / <sub>4</sub>	11/8	20	6 <sup>3</sup> / <sub>4</sub>	6	
16	21 <sup>1</sup> / <sub>4</sub>	1	16	5 <sup>1</sup> / <sub>4</sub>	4 <sup>1</sup> / <sub>2</sub>	22 <sup>1</sup> / <sub>2</sub>	11/4	20	7 <sup>1</sup> / <sub>4</sub>	6 <sup>1</sup> / <sub>2</sub>	
18	22 <sup>3</sup> / <sub>4</sub>	11/8	16	5 <sup>3</sup> / <sub>4</sub>	4 <sup>3</sup> / <sub>4</sub>	24 <sup>3</sup> / <sub>4</sub>	11/4	24	7 <sup>1</sup> / <sub>2</sub>	6 <sup>3</sup> / <sub>4</sub>	

125/150 LB. FLANGE						250/300 LB. FLANGE					
Nom. Pipe Size	Bolt Circle Dia.	Bolt Dia.	No. of Bolts	*Stud Len.	Bolt Len.	Bolt Circle Dia.	Bolt Dia.	No. of Bolts	*Stud Len.	Bolt Len.	
20	25	1 <sup>1</sup> / <sub>8</sub>	20	6	5 <sup>1</sup> / <sub>4</sub>	27	1 <sup>1</sup> / <sub>4</sub>	24	8	7	
22	27 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	20	6 <sup>1</sup> / <sub>2</sub>	5 <sup>1</sup> / <sub>2</sub>	29 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	24	8 <sup>3</sup> / <sub>4</sub>	7 <sup>1</sup> / <sub>2</sub>	
24	29 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>4</sub>	20	6 <sup>3</sup> / <sub>4</sub>	5 <sup>3</sup> / <sub>4</sub>	32	1 <sup>1</sup> / <sub>2</sub>	24	9	7 <sup>3</sup> / <sub>4</sub>	
26	31 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	24	7	6	34 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>8</sub>	28	10	8 <sup>3</sup> / <sub>4</sub>	
30	36	1 <sup>1</sup> / <sub>4</sub>	28	7 <sup>1</sup> / <sub>4</sub>	6 <sup>1</sup> / <sub>4</sub>	39 <sup>1</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>4</sub>	28	11 <sup>1</sup> / <sub>4</sub>	10	
34	40 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>	32	8	7	43 <sup>1</sup> / <sub>2</sub>	1 <sup>7</sup> / <sub>8</sub>	28	12 <sup>1</sup> / <sub>4</sub>	10 <sup>3</sup> / <sub>4</sub>	
36	42 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	32	8 <sup>1</sup> / <sub>4</sub>	7	46	2	32	12 <sup>3</sup> / <sub>4</sub>	11 <sup>1</sup> / <sub>4</sub>	
42	49 <sup>1</sup> / <sub>2</sub>	1 <sup>1</sup> / <sub>2</sub>	36	8 <sup>3</sup> / <sub>4</sub>	7 <sup>1</sup> / <sub>4</sub>	52 <sup>3</sup> / <sub>4</sub>	2	36	13 <sup>3</sup> / <sub>4</sub>	13 <sup>1</sup> / <sub>2</sub>	

\*1<sup>1</sup>/<sub>16</sub>" Raised Face

Stud lengths for lap joint flanges are equal to lengths shown plus the thickness of two laps of the stub ends.

## BOLTING DIMENSIONS FOR 400 LB./600LB. STEEL FLANGE

Nom Pipe Size	400 LB. STEEL FLANGES				600 LB. STEEL FLANGES			
	Diam of Bolt Circle	Diam of Bolts	No. of Bolts	Length of Studs $\frac{1}{4}$ " Raised Face	Diam of Bolt Circle	Diam of Bolts	No. of Bolts	Length of Studs $\frac{1}{4}$ " Raised Face
1/2	2 <sup>5</sup> / <sub>8</sub>	1/2	4	3	2 <sup>5</sup> / <sub>8</sub>	1/2	4	3
3/4	3 <sup>1</sup> / <sub>4</sub>	5/8	4	3 <sup>1</sup> / <sub>4</sub>	3 <sup>1</sup> / <sub>4</sub>	5/8	4	3 <sup>1</sup> / <sub>4</sub>
1	3 <sup>1</sup> / <sub>2</sub>	5/8	4	3 <sup>1</sup> / <sub>2</sub>	3 <sup>1</sup> / <sub>2</sub>	5/8	4	3 <sup>1</sup> / <sub>2</sub>
1 1/4	3 <sup>7</sup> / <sub>8</sub>	5/8	4	3 <sup>3</sup> / <sub>4</sub>	3 <sup>7</sup> / <sub>8</sub>	5/8	4	3 <sup>3</sup> / <sub>4</sub>
1 1/2	4 <sup>1</sup> / <sub>2</sub>	3/4	4	4	4 <sup>1</sup> / <sub>2</sub>	3/4	4	4
2	5	5/8	8	4	5	5/8	8	4
2 1/2	5 <sup>7</sup> / <sub>8</sub>	3/4	8	4 <sup>1</sup> / <sub>2</sub>	5 <sup>7</sup> / <sub>8</sub>	3/4	8	4 <sup>1</sup> / <sub>4</sub>
3	6 <sup>5</sup> / <sub>8</sub>	3/4	8	4 <sup>3</sup> / <sub>4</sub>	6 <sup>5</sup> / <sub>8</sub>	3/4	8	4 <sup>3</sup> / <sub>4</sub>
3 1/2	7 <sup>1</sup> / <sub>4</sub>	7/8	8	5 <sup>1</sup> / <sub>4</sub>	7 <sup>1</sup> / <sub>4</sub>	7/8	8	5 <sup>1</sup> / <sub>4</sub>
4	7 <sup>7</sup> / <sub>8</sub>	7/8	8	5 <sup>1</sup> / <sub>4</sub>	8 <sup>1</sup> / <sub>2</sub>	7/8	8	5 <sup>1</sup> / <sub>2</sub>
5	9 <sup>1</sup> / <sub>4</sub>	7/8	8	6 <sup>1</sup> / <sub>2</sub>	10 <sup>1</sup> / <sub>2</sub>	1	8	6 <sup>1</sup> / <sub>4</sub>
6	10 <sup>5</sup> / <sub>8</sub>	7/8	12	5 <sup>3</sup> / <sub>4</sub>	11 <sup>1</sup> / <sub>2</sub>	1	12	6 <sup>1</sup> / <sub>2</sub>
8	13	1	12	6 <sup>1</sup> / <sub>2</sub>	13 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	12	7 <sup>1</sup> / <sub>2</sub>
10	15 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>8</sub>	16	7 <sup>1</sup> / <sub>4</sub>	17	1 <sup>1</sup> / <sub>4</sub>	16	8 <sup>1</sup> / <sub>4</sub>
12	17 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	16	7 <sup>3</sup> / <sub>4</sub>	19 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	20	8 <sup>1</sup> / <sub>2</sub>
14	20 <sup>1</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>4</sub>	20	8	20 <sup>3</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>8</sub>	20	9
16	22 <sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>8</sub>	20	8 <sup>1</sup> / <sub>2</sub>	23 <sup>3</sup> / <sub>4</sub>	1 <sup>1</sup> / <sub>2</sub>	20	9 <sup>3</sup> / <sub>4</sub>
18	24 <sup>3</sup> / <sub>4</sub>	1 <sup>3</sup> / <sub>8</sub>	24	8 <sup>3</sup> / <sub>4</sub>	25 <sup>3</sup> / <sub>4</sub>	1 <sup>5</sup> / <sub>8</sub>	20	10 <sup>1</sup> / <sub>2</sub>

Nom Pipe Size	400 LB. STEEL FLANGES				600 LB. STEEL FLANGES			
	Diam of Bolt Circle	Diam of Bolts	No. of Bolts	Length of Studs $\frac{1}{4}$ " Raised Face	Diam of Bolt Circle	Diam of Bolts	No. of Bolts	Length of Studs $\frac{1}{4}$ " Raised Face
20	27	1 <sup>1</sup> / <sub>2</sub>	24	9 <sup>1</sup> / <sub>2</sub>	28 <sup>1</sup> / <sub>2</sub>	1 <sup>5</sup> / <sub>8</sub>	24	11 <sup>1</sup> / <sub>4</sub>
22	29 <sup>1</sup> / <sub>4</sub>	1 <sup>5</sup> / <sub>8</sub>	24	10	30 <sup>5</sup> / <sub>8</sub>	1 <sup>3</sup> / <sub>4</sub>	24	12
24	32	1 <sup>3</sup> / <sub>4</sub>	24	10 <sup>1</sup> / <sub>2</sub>	33	1 <sup>7</sup> / <sub>8</sub>	24	12 <sup>3</sup> / <sub>4</sub>
26	34 <sup>1</sup> / <sub>2</sub>	1 <sup>3</sup> / <sub>4</sub>	28	11 <sup>1</sup> / <sub>2</sub>	36	1 <sup>7</sup> / <sub>8</sub>	28	13 <sup>1</sup> / <sub>4</sub>
30	39 <sup>1</sup> / <sub>4</sub>	2	28	13	40 <sup>1</sup> / <sub>4</sub>	2	28	14
34	43 <sup>1</sup> / <sub>2</sub>	2	28	13 <sup>3</sup> / <sub>4</sub>	44 <sup>1</sup> / <sub>2</sub>	2 <sup>1</sup> / <sub>4</sub>	28	15
36	46	2	32	14	47	2 <sup>1</sup> / <sub>2</sub>	28	15 <sup>3</sup> / <sub>4</sub>
42	52 <sup>3</sup> / <sub>4</sub>	2 <sup>1</sup> / <sub>2</sub>	32	16 <sup>1</sup> / <sub>4</sub>	53 <sup>3</sup> / <sub>4</sub>	2 <sup>3</sup> / <sub>4</sub>	28	17 <sup>1</sup> / <sub>2</sub>

Stud lengths for lap joint flanges are equal to lengths shown minus 1/2"  
plus the thickness of two laps of the stub ends.

## ASTM CARBON STEEL PIPE &amp; FLANGE SPECIFICATIONS

Pipe and Tubing Description and Applications	Spec No.	ASTM or Type	Grade Strength PSI	Yield Point or Strength PSI	Elongation (% in 2")				Chemical Composition, %				
					STD Round	Rectangular			C	MN	P	S	
						t	5/16"	5/16"					
Seamless milled steel pipe for high-temperature service, suitable for bending, flanging & similar forming operations.	(1) A106	A	48,000	30,000	28 long. OR (4) 20 trans.	17.5+ or 12.5+	56t	35	.25 max	.27 to .93	.048 max	.058 max	
As above, except use Grade A for close coiling, cold bending or forge welding.	(1) A106	B	60,000	35,000	28 long. OR (4) 12 trans.	17.5+ or 6.5+	56t	35	30 max	.27 to 1.06	.048 max	.058 max	
Black or hot-dip galvanize seamless or res-welded steel pipe suitable for coiling, bending, flanging, & other special purposes, suitable for welding.	A 53	A	48,000	30,000	28	17.5+	56t	35	(2)	-	(3)	-	
As above, except use Grade A for close coiling, cold bending or forge welding.	A 53	B	60,000	35,000	22	15+	48t	30	(2)	-	(3)	-	
Black or hot-dip galvanize seamless or res. welded steel pipe suitable for ordinary uses. (When tension, flattening or bend test required, order to A-53).	A 120 (obsolete)	-	-	-	-	-	-	-	-	-	-	-	
Resistance welded steel pipe for liquid, gas or vapor.	A 135	A	48,000	30,000	-	17.5+	56t	35	-	-	.050 max	.060 max	
As above, except use Grade A for flanging & bending.	A 135	B	60,000	35,000	-	15+	48t	30	-	-	.050 max	.060 max	

**ASTM CARBON STEEL PIPE & FLANGE SPECIFICATIONS**

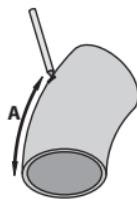
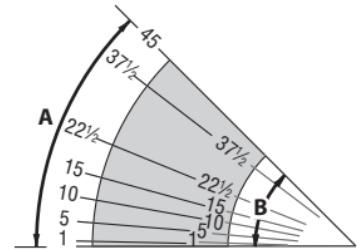
Pipe and Tubing Description and Applications	Spec No.	ASTM or Type	Grade Strength PSI	Yield Point or Strength PSI	Elongation (% in 2")				Chemical Composition, %			
					STD Round	Rectangular			C	MN	P	S
Electric-fusion-welded strait- or spiral-seam pipe for liquid, gas or vapor from mill grades of plate.	A 139	A	48,000	30,000	—	17.5+	56t	35	—	.30 to 1.00	.040 max	.050 max
As above	A 139	B	60,000	35,000	—	15+	48t	30	.30 max	.30 to 1.00	.040 max	.050 max
Forged Pipe, Flanges Description and Applications												
Forged or rolled steel pipe flanges, fittings (6) values and parts for high temperature service. Heat treatment required; may be annealed or normalized.	A105	I	60,000	30,000	25		—	—	.35 (5) max	.90 max	.05 max	.05 max
As above	A 105	II	70,000	36,000	22		—	—	.35 (5) max	.90 max	.05 max	.05 max
As above except for general service. Heat treatment is not required.	A 181	I	60,000	30,000	22		—	—	.35 (5) max	.90 max	.05 max	.05 max
As above	A 181	II	70,000	36,000	18		—	—	.35 (5) max	.90 max	.05 max	.05 max

(1) 0.10% silicon minimum.

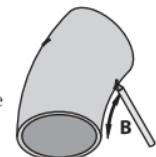
(2) Open hearth, 0.13 max for 1/8" and 1/4" size resistance welded pipe only

(3) Seamless: open hearth 0.048 max, acid bessemer 0.11 max;  
Res. welded: open hearth 0.050 max.(4) Longitudinal or transverse direction of test specimen with respect to  
pipe axis(5) When flanges will be subject to fusion welding, carbon content shall be  
≤0.35%. If carbon is ≤0.35%, it may be necessary to add silicon to  
meet required tensile properties. The silicon content shall be ≤0.35%.(6) Factor-made Wrought Carbon Steel and Ferritic Alloy Steel Welding  
Fitting Specifications are covered under ASTM A234.

## HOW TO CUT ODD-ANGLE ELBOWS



**Step 1.** Measure distance on outside arc using the values from the previous table & make a mark.



**Step 2.** Measure distance on inside arc using the values from the table below & make a mark.



**Step 3.** Wrap tape around elbow & mark cutting line.

Nom.	O.D.	1°		5°		10°		15°		22 1/2°		37 1/2°		45°	
		A	B	A	B	A	B	A	B	A	B	A	B	A	B
2	2.38	1/16	1/32	3/8	5/32	23/32	5/16	13/32	15/32	121/32	23/32	23/4	13/16	39/32	17/16
2 1/2	2.88	3/32	1/32	7/16	3/16	29/32	13/32	111/32	19/32	21/32	29/32	313/32	11/2	41/16	113/16
3	3.50	3/32	1/16	17/32	1/4	13/32	15/32	15/8	23/32	215/32	13/32	43/32	113/16	429/32	25/32
3 1/2	4.00	1/8	1/16	5/8	9/32	11/4	9/16	129/32	27/32	227/32	19/32	43/4	21/8	511/16	29/16
4	4.50	5/32	1/16	23/32	5/16	17/16	21/32	25/32	31/32	31/4	115/32	513/32	215/32	615/32	215/16
5	5.56	3/16	3/32	29/32	13/32	125/32	13/16	211/16	11/4	41/32	127/32	623/32	33/32	81/16	323/32
6	6.63	7/32	3/32	11/16	1/2	25/32	1	37/32	11/2	427/32	27/32	81/16	323/32	921/32	415/32
8	8.63	9/32	1/8	17/16	21/32	227/32	111/32	49/32	2	613/32	31/32	1011/16	51/32	1213/16	61/32
10	10.75	11/32	5/32	125/32	27/32	39/16	111/16	511/32	217/32	8	325/32	1311/32	65/16	16	79/16
12	12.75	7/16	3/16	21/8	1	41/4	21/32	63/8	31/32	99/16	49/16	1531/32	719/32	195/32	91/8
14	14.00	1/2	1/4	27/16	7/32	47/8	27/16	711/32	321/32	11	51/2	185/16	95/32	22	11
16	16.00	9/16	9/32	225/32	113/32	519/32	225/32	83/8	43/16	129/16	69/32	2015/16	1015/32	251/8	19/16
18	18.00	5/8	5/16	35/32	19/16	69/32	35/32	97/16	423/32	141/8	71/16	239/16	1125/32	289/32	141/8
20	20.00	11/16	11/32	31/2	13/4	631/32	31/2	1015/32	51/4	1523/32	727/32	23/16	133/32	3113/32	1523/32
22	22.00	25/32	3/8	327/32	129/32	711/16	327/32	1117/32	53/4	179/32	85/8	2813/16	1413/32	349/16	179/32
24	24.00	27/32	13/32	43/16	23/32	83/8	43/16	129/16	69/32	1827/32	97/16	3113/32	1523/32	3711/16	1827/32
26	26.00	29/32	15/32	417/32	29/32	91/16	417/32	135/8	613/16	2013/32	107/32	341/32	171/32	4027/32	2013/32
30	30.00	11/16	17/32	51/4	25/8	1015/32	51/4	1523/32	727/32	239/16	1125/32	399/32	195/8	471/8	239/16
34	34.00	13/16	19/32	515/16	231/32	117/8	515/16	1713/16	829/32	2623/32	1311/32	441/2	221/4	5313/32	2623/32
36	36.00	11/4	5/8	69/32	35/32	129/16	69/32	1827/32	97/16	289/32	141/8	471/8	239/16	569/16	289/32
42	42.00	115/32	23/32	711/32	321/32	1421/32	711/32	22	11	33	161/2	5431/32	271/2	6531/32	33

## ALIGNMENT OF PIPE

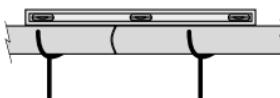
Proper alignment is important if a piping system is to be correctly fabricated.

Poor alignment may result in welding difficulties and a system that does not function properly.

Welding rings may be employed to assure proper alignment as well as the correct welding gap. In addition to using welding rings, some simple procedures can be followed to assist the pipe fitter. Below and on the following page are alignment procedures commonly used by today's craftsmen.

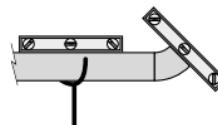
### PIPE-TO-PIPE

1. Level one length of pipe using spirit level.
2. Bring lengths together leaving only small welding gap.
3. Place spirit level over both pipes as shown and maneuver unpositioned length until both are level.
4. Tack weld top and bottom.
5. Rotate pipe 90°.
6. Repeat procedure.



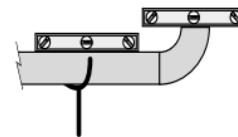
### 45° ELBOW-TO-PIPE

1. Level pipe using spirit level.
2. Place fitting to pipe leaving small welding gap.
3. Place 45" spirit level on face of elbow and maneuver elbow until bubble is centered.
4. Tack weld in place.



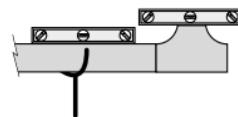
### 90° ELBOW-TO-PIPE

1. Level pipe using spirit level.
2. Place fitting to pipe leaving small welding gap.
3. Place spirit level on face of elbow and maneuver elbow until level.
4. Tack weld in place.



### TEE-TO-PIPE

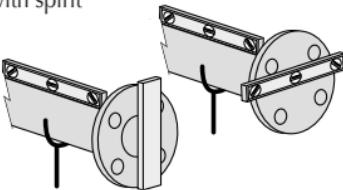
1. Level pipe using spirit level.
2. Place tee to pipe leaving small welding gap.
3. Place spirit level on face of tee and maneuver tee until level.
4. Tack weld in place.



## ALIGNMENT OF PIPE, CONT'D.

### FLANGE-TO-PIPE

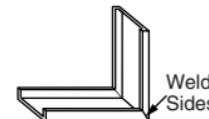
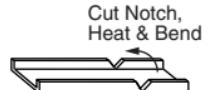
1. Bring flange to pipe end leaving small welding gap.
2. Align top two holes of flange with spirit level.
3. Tack weld in place.
4. Center square on face of flange as shown.
5. Tack weld in place.
6. Check sides in same way.



### JIG FOR SMALL DIAMETER PIPING

The jig is made from channel iron 3' 9" long. Use  $\frac{1}{8}$ " x  $1\frac{1}{2}$ " for pipe sizes  $1\frac{1}{4}$ " thru 3";  $\frac{1}{8}$ " x  $\frac{3}{4}$ " for sizes 1" or smaller.

1. Cut out  $90^\circ$  notches about 9" from end.
2. Heat bottom of notch with torch.
3. Bend channel iron to  $90^\circ$  angle and weld sides.
4. Place elbow in jig and saw half thru sides of channel iron as shown. Repeat this step with several elbows so jig may be used for different operations.
5. A used hack saw blade placed in notch as shown will provide proper welding gap.



## DRILL SIZES FOR NPT PIPE TAPS

Tap Size	Threads/In.	Drill Dia.
1/8	27	R
1/4	18	7/16
3/8	18	37/64
1/2	14	23/32
5/8	14	59/64
1	11 1/2	1 5/32
1 1/4	11 1/2	1 1/2
1 1/2	11 1/2	1 47/64
2	11 1/2	2 7/32
2 1/2	8	2 5/8
3	8	3 1/4
3 1/2	8	3 3/4
4	8	4 1/4

## TAP & DRILL SIZES

(Unified National Coarse)

Tap Size	Threads/In.	Drill Size
1/4	20	7
5/16	18	F
3/8	16	5/16
7/16	14	U
1/2	13	27/64
9/16	12	31/64
5/8	11	17/32
3/4	10	21/32
7/8	9	49/64
1	8	7/8
1 1/8	7	63/64
1 1/4	7	17/64
1 3/8	6	17/32
1 1/2	6	1 11/32
1 3/4	5	1 9/16
2	4 1/2	1 25/32

## PIPE & WATER WEIGHT/FOOT

Nom. Pipe Size	WEIGHT (Lb.)		WEIGHT (Lb.)	
	STD Pipe	Water	XS Pipe	Water
1/2	0.851	0.132	1.088	0.101
3/4	1.131	0.230	1.474	0.188
1	1.679	0.374	2.172	0.311
1 1/4	2.273	0.648	2.997	0.555
1 1/2	2.718	0.882	3.631	0.765
2	3.653	1.455	5.022	1.280
2 1/2	5.793	2.076	7.661	1.837
3	7.580	3.200	10.250	2.864
3 1/2	9.110	4.280	12.510	3.850
4	10.790	5.510	14.980	4.980
5	14.620	8.660	20.780	7.890
6	18.970	12.510	28.570	11.290
8	28.550	21.690	43.390	19.800
10	40.480	34.100	54.740	32.300
12	49.580	49.000	65.420	47.000
14	54.570	59.700	72.090	57.500
16	62.580	79.100	82.770	76.500
18	70.590	101.200	93.450	98.400
20	78.600	126.000	104.130	122.800
24	94.620	183.800	125.490	180.100
30	119.000	291.200	158.000	286.200

**WEIGHT/FOOT - SEAMLESS BRASS & COPPER PIPE**

Nominal Pipe Size	REGULAR			EXTRA STRONG		
	Yellow Brass	Red Brass	Copper	Yellow Brass	Red Brass	Copper
1/2	0.91	0.93	0.96	1.19	1.23	1.25
3/4	1.23	1.27	1.30	1.62	1.67	1.71
1	1.73	1.78	1.82	2.39	2.49	2.51
1 1/4	2.56	2.63	2.69	3.29	3.39	3.46
1 1/2	3.04	3.13	3.20	3.99	4.10	4.19
2	4.01	4.12	4.22	5.51	5.67	5.80

**BOILING POINTS OF WATER AT VARIOUS PRESSURES**

Vacuum, in Inches of Mercury	Boiling Point	Vacuum, in Inches of Mercury	Boiling Point	Pressure Gauge Lbs	Boiling Point
29	76.62	14	181.82	0	212.0
28	99.93	13	184.61	1	215.6
27	114.22	12	187.21	2	218.5
26	124.77	11	189.75	4	224.4
25	133.22	10	192.19	6	229.8
24	140.31	9	194.50	8	234.8
23	146.45	8	196.73	10	239.4
22	151.87	7	198.87	15	249.8
21	156.75	6	200.96	25	266.8
20	161.19	5	202.25	50	297.7
19	165.24	4	204.85	75	320.1
18	169.00	3	206.70	100	337.9
17	172.51	2	208.50	125	352.9
16	175.80	1	210.25	200	387.9
15	178.91				

**WATER PRESSURE TO FEET HEAD**

<b>Lbs./Sq.In. Feet Head</b>	<b>Lbs./Sq.In. Feet Head</b>	<b>Lbs./Sq.In. Feet Head</b>	
1	2.31	40	92.36
2	4.62	50	115.45
3	6.93	60	138.54
4	9.24	70	161.63
5	11.54	80	184.72
6	13.85	90	207.81
7	16.16	100	43.31
8	18.47	110	47.64
9	20.78	120	51.97
10	23.09	130	56.30
15	34.63	140	60.63
20	46.18	150	64.96
25	57.72	160	69.29
30	69.27	170	73.63

**FEET HEAD TO WATER PRESSURE**

<b>Feet Head</b>	<b>Lbs./Sq.In.</b>	<b>Feet Head</b>	<b>Lbs./Sq.In.</b>	<b>Feet Head</b>	<b>Lbs./Sq.In.</b>
1	0.43	40	17.32	180	77.96
2	0.87	50	21.65	200	86.62
3	1.30	60	25.99	250	108.27
4	1.73	70	30.32	300	129.93
5	2.17	80	34.65	350	151.58
6	2.60	90	38.98	400	173.24
7	3.03	100	43.31	500	216.55
8	3.46	110	47.64	600	259.85
9	3.90	120	51.97	700	303.16
10	4.33	130	56.30	800	346.47
15	6.50	140	60.63	900	389.78
20	8.66	150	64.96	1,000	433.00
25	10.83	160	69.29		
30	12.99	170	73.63		

**NOTE:** One foot of water at 62°F equals 0.433 pound pressure per square inch. To find the pressure per square inch for any feet head not given in the table above, multiply the feet head by 0.433.

## FLOW CONVERSION CHART

The accompanying chart provides fast answers to many problems that may confront the pipe fitter. Procedures for using the chart are as follows:

Note that there are three sets of figures shown in connection with the extreme left-hand column **A**.

"Standard" gives the internal diameter of standard pipe (somewhat greater than 1" for 1 in. standard pipe).

"Exact" gives the exact diameter.

"Extra Heavy" gives the internal diameter of extra heavy pipe.

**EXAMPLE:** How much water is passing through a pipe with parameters:

I.D. of exactly 1 in.

Velocity of the water being 3 F.P.S.

To apply the chart to the problem locate 1 in. in column "**A**" using the scale "**Exact**" and run a straight line from the point through the 3 in column "**C**". From the intersection of this line with column "**B**", run a straight line horizontally to column "**G**". The intersection of this line at columns "**D**", "**E**" and "**F**" gives the following information:

"**D**" shows the cubic feet/minute flowing through the pipe.

"**E**" shows the volume of flow in gallons/minute

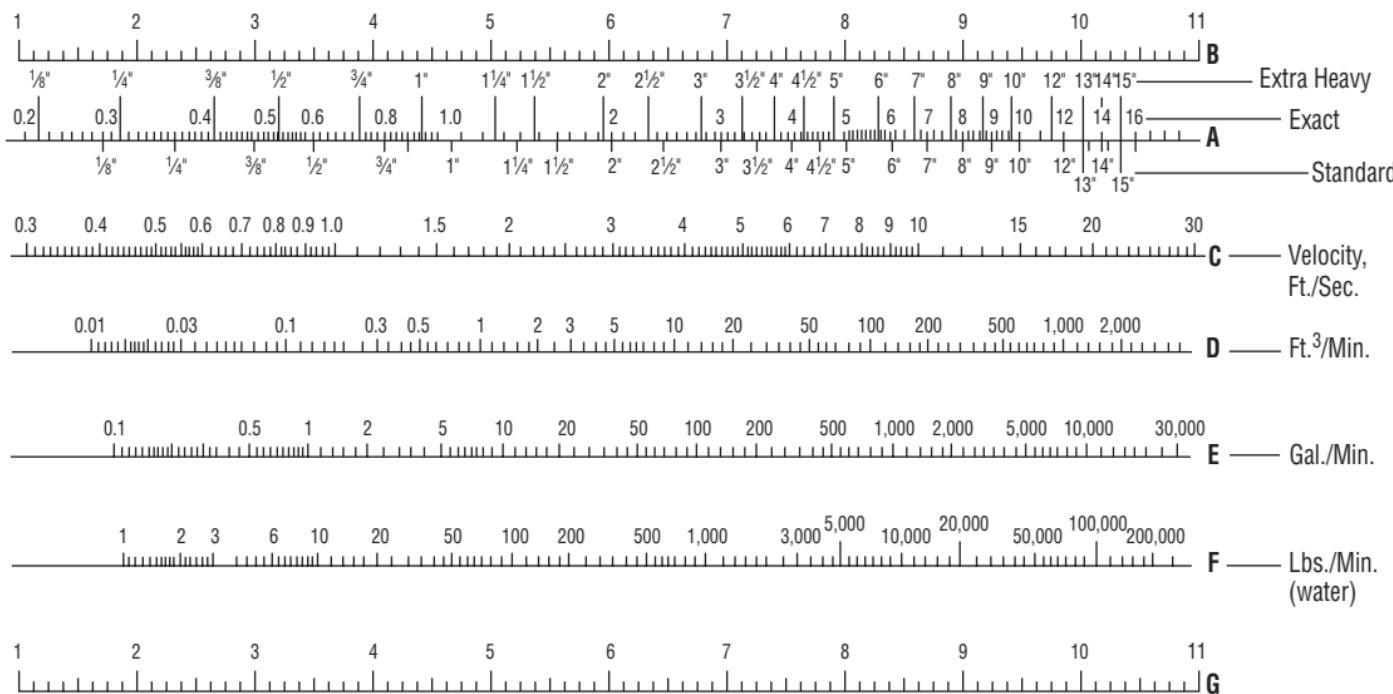
"**F**" gives the weight of the water in pounds/minute. (For liquids other than water, multiply the value of column "**F**" by the specific gravity of the liquid for accurate weight conversion.)

If a quantity in columns "**D**", "**E**" and "**F**" is known then velocity may be determined by reversing the procedure. Draw a horizontal line from the known point to column "**G**". From this intersection draw a line to the exact I.D. of the pipe in column "**A**" and extend this line to cross column "**C**". The intersection with column "**C**" gives the velocity in feet/second.

The chart can be used as a conversion chart to determine the number of gallons in a certain number of cubic feet of liquid. The horizontal line already drawn to determine answers in columns "**C**" and "**D**" will provide the answer to the conversion in column "**E**".

A little practice will prove this chart to be a real time-saver.

## FLOW CONVERSION CHART



## HEAT LOSSES FROM HORIZONTAL BARE STEEL PIPE

(BTU per hour per linear foot at 70°F room temperature)

PIPE Nom. Pipe Size	HOT WATER (180°F)	STEAM 5 PSIG (20 PSIA)
1/2	60	96
3/4	73	118
1	90	144
1 1/4	112	179
1 1/2	126	202
2	155	248
2 1/2	185	296
3	221	355
3 1/2	244	401
4	279	448

## COLORS & APPROXIMATE TEMPERATURE FOR CARBON STEEL

Black Red .....	990°F
Dark Blood Red.....	1,050°F
Dark Cherry Red .....	1,175°F
Medium Cherry Red.....	1,250°F
Full Cherry Red .....	1,375°F
Light Cherry, Scalding .....	1,550°
Salmon, Free Scalding .....	1,650°F
Light Salmon .....	1,725°F
Yellow .....	1,825°F
Light Yellow .....	1,975°F
White.....	2,220°F

## TOTAL THERMAL EXPANSION OF PIPING MATERIAL

(Inches Per 100 Ft. Above 32°F)

Temp °F	Carbon & Steel		Brass		
	Carbon Molly	Cast Iron	Copper	Bronze	Wrought Iron
32	0.0	0.0	0.0	0.0	0.0
100	0.5	0.5	0.8	0.8	0.5
150	0.8	0.8	1.4	1.4	0.9
200	1.2	1.2	2.0	2.0	1.3
250	1.7	1.5	2.7	2.6	1.7
300	2.0	1.9	3.3	3.2	2.2
350	2.5	2.3	4.0	3.9	2.6
400	2.9	2.7	4.7	4.6	3.1
450	3.4	3.1	5.3	5.2	3.6
500	3.8	3.5	6.0	5.9	4.1
550	4.3	3.9	6.7	6.5	4.6
600	4.8	4.4	7.4	7.2	5.2
650	5.3	4.8	8.2	7.9	5.6
700	5.9	5.3	9.0	8.5	6.1
750	6.4	5.8	—	—	6.7
800	7.0	6.3	—	—	7.2
850	7.4	—	—	—	—
900	8.0	—	—	—	—
950	8.5	—	—	—	—
1000	9.1	—	—	—	—

## WEIGHTS OF METALS

Material	Chemical Symbol	Wt.in Lbs. Per Cubic In.	Wt. in Lbs. Per Cubic Ft.
Aluminum	Al	0.093	160
Antimony	Sb	0.2422	418
Brass	—	0.303	524
Bronze	—	0.32	552
Chromium	Cr	0.2348	406
Copper	Cu	0.323	558
Gold	Au	0.6975	1,205
Iron (cast)	Fe	0.26	450
Iron (wrought)	Fe	0.2834	490
Lead	Pb	0.4105	710
Manganese	Mn	0.2679	463
Mercury	Hg	0.491	849
Molybdenum	Mo	0.309	534
Monel	—	0.318	550
Platinum	Pt	0.818	1,413
Steel (mild)	—	0.2816	490
Steel (stainless)	—	0.277	484
Tin	Sn	0.265	459
Titanium	Ti	0.1278	221
Zinc	Zn	0.258	446

**SPECIFIC GRAVITY OF GASES**

Dry Air (1 cu. Ft. at 60°F. & 29.92" Hg. Weighs.07638 pound). .	1.000
Acetylene.....	C <sub>2</sub> H <sub>2</sub> .....
Ethane .....	C <sub>2</sub> H <sub>4</sub> .....
Methane .....	CH <sub>4</sub> .....
Ammonia .....	NH <sub>3</sub> .....
Carbon-dioxide.....	CO <sub>2</sub> .....
Carbon_monoxide.....	CO.....
Butane .....	C <sub>4</sub> H <sub>10</sub> .....
Butene .....	C <sub>4</sub> H <sub>8</sub> .....
Chlorine.....	Cl <sub>2</sub> .....
Helium.....	He .....
Hydrogen.....	H <sub>2</sub> .....
Nitrogen.....	N <sub>2</sub> .....
Oxygen.....	O <sub>2</sub> .....
	1.1053

**TYPICAL BTU VALUES OF FUELS****ASTM RANK SOLIDS**

Anthracite Class I	11,230
Bituminous Class II Group 1	14,100
Bituminous Class II Group 3	13,080
Sub-Bituminous Class III Group 1	10,810
Sub-Bituminous Class III Group 2	9,670

**BTU VALUES PER POUND****LIQUIDS**

Fuel Oil No. 1	136,000
Fuel Oil No. 2	138,000
Fuel Oil No. 4	145,000
Fuel Oil No. 5	148,000
Fuel Oil No. 6	152,000

**BTU VALUES PER GALLON****GASES**

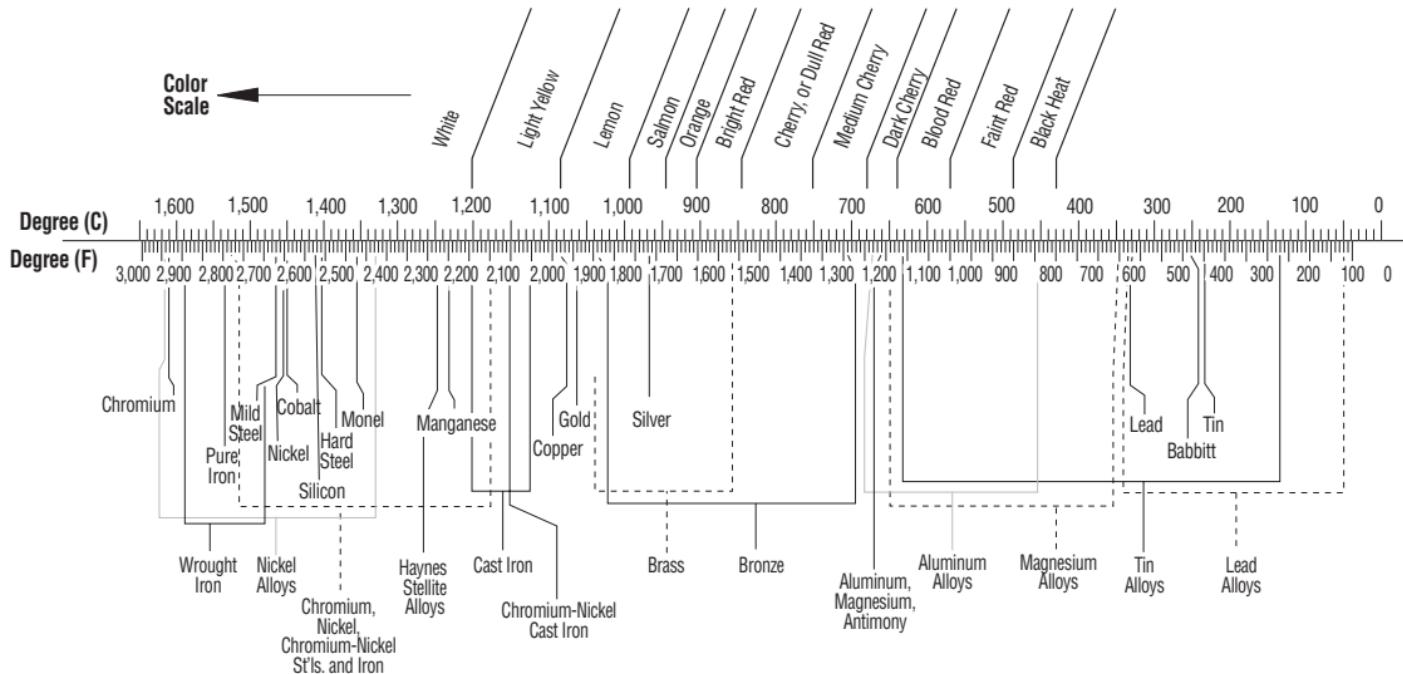
Natural Gas	935 to 1132
Producers Gas	163
Illuminating Gas	534
Mixed (Coke oven and water gas)	545

**BTU VALUES PER CU. FT.****SPECIFIC GRAVITY OF LIQUIDS**

Liquid	Temp °F	Specific Gravity
Water (1 cu.-ft. weights 62.41 lb.)	50	1.00
Brine (Sodium Chloride 25%)	32	1.20
Pennsylvania Crude Oil	80	0.85
Fuel Oil No. 1 and 2	85	0.95
Gasoline	80	0.74
Kerosene	85	0.82
Lubricating Oil SAE 10-20-30	115	0.94

## MELTING POINT OF METALS

Melting Points of Metals  
& Alloys of Practical Importance



## USEFUL DEFINITIONS

**ALLOY STEEL:** A Steel which owes its distinctive properties to elements other than carbon.

**AREA OF A CIRCLE:** The measurement of the surface within a circle. To find the area of a circle, multiply the product of the radius times the radius by Pi (3.142). Commonly written  $A = \pi r^2$ .

**BRAZE WELD OR BRAZING:** A process of joining metals using a nonferrous filler metal or alloy, the melting point of which is higher than 800°F but lower than that of the metals to be joined.

**BUTT WELD:** A circumferential weld in pipe fusing the abutting pipe walls completely from inside wall to outside wall.

**CARBON STEEL:** A steel which owes its distinctive properties chiefly to the various percentages of carbon (as distinguished from the other elements) which it contains.

**CIRCUMFERENCE OF A CIRCLE:** The measurement around the perimeter of a circle. To find the circumference, multiply Pi (3.142) by the diameter. (Commonly written as  $\pi d$ ).

**COEFFICIENT OF EXPANSION:** A number indicating the degree of expansion or contraction of a substance.

The coefficient of expansion is not constant and varies with changes in temperature. For linear expansion it is expressed as the change in length of one unit of length of a substance having one degree rise in temperature.

**CORROSION:** The gradual destruction or alteration of a metal or alloy caused by direct chemical attack or by electrochemical reaction.

**CREEP:** The plastic flow of pipe within a system; the permanent set in metal caused by stresses at high temperatures. Generally associated with a time rate of deformation.

**DIAMETER OF A CIRCLE:** A straight line drawn through the center of a circle from one extreme edge to the other. Equal to twice the radius.

**DUCTILITY:** The property of elongation, above the elastic limit, but under the tensile strength.

A measure of ductility is the percentage of elongation of the fractured piece over its original length.

**ELASTIC LIMIT:** The greatest stress which a material can withstand without a permanent deformation after release of the stress.

**EROSION:** The gradual destruction of metal or other material by the abrasive action of liquids, gases, solids or mixtures thereof.

**RADIUS OF A CIRCLE:** A straight line drawn from the center to the extreme edge of a circle.

**SOCKET FITTING:** A fitting used to join pipe in which the pipe is inserted into the fitting. A fillet weld is then made around the edge of the fitting and the outside wall of the pipe.

## USEFUL DEFINITIONS

**SOLDERING:** A method of joining metals using fusible alloys, formerly tin and lead, having melting points under 700°F

**STRAIN:** Change of shape or size of a body produced by the action of a stress.

**STRESS:** The intensity of the internal, distributed forces which resist a change in the form of a body. When external forces act on a body they are resisted by reactions within the body which are termed stresses.

**TENSILE STRESS:** One that resists a force tending to pull a body apart.

**COMPRESSIVE STRESS:** One that resists a force tending to crush a body.

**shearing stress:** One that resists a force tending to make one layer of a body slide across another layer.

**TORSIONAL STRESS:** One that resists forces tending to twist a body.

**TENSILE STRENGTH:** The maximum tensile stress which a material will develop. The tensile strength is usually considered to be the load in pounds per square inch at which a test specimen ruptures.

**TURBULENCE:** Any deviation from parallel flow in a pipe due to rough inner walls, obstructions or directional changes.

**VELOCITY:** Time rate of motion in a given direction and sense, usually expressed in feet per second.

**VOLUME OF A PIPE:** The measurement of the space within the walls of the pipe. To find the volume of a pipe, multiply the length (or height) of the pipe by the product of the inside radius times the inside radius by Pi (3.142). Commonly written as  $V = h\pi r^2$ .

**WELDING:** A process of joining metals by heating until they are fused together, or by heating and applying pressure until there is a plastic joining action. Filler metal may or may not be used.

**YIELD STRENGTH:** The stress at which a material exhibits a specified limiting permanent set. (.2% or .5%)

**UNIT CONVERSIONS****FLOW**

1 gpm	= 0.134 cu. ft. per min
	= 500 lb. per hr. x sp. gr.
500 lb. per hr.	= 1 gpm / sp. gr.
1 cu. ft. per min. (cfm)	= 448.8 gal. per hr. (gph)

**POWER**

1 Btu per hr.	= 0.293 watt
	= 12.96 ft. lb. per min.
	= 0.00039 hp
1 ton refrigeration (U.S.)	= 288,000 Btu per 24 hr.
	= 12,000 Btu per hr.
	= 200 Btu per min.
	= 83.33 lb. ice melted per 24 hr. from & at 32°F.
	= 2,000 lb. ice melted per 24 hr. from & at 32°F
1 hp	= 550 ft. lb. per sec.
	= 746 watt
	= 2,545 Btu per hr.
1 boiler hp	= 33,480 Btu per hr.
	= 34.5 lb. water evap. per hr. from & at 212°F
	= 9.8 kw.
1 kw.	= 3,413 Btu per hr.

**MASS**

1 lb. (avoir.)	= 16 oz. (avoir.)
	= 7,000 grain
1 ton (short)	= 2,000 lb.
1 ton (long)	= 2,240 lb.

**PRESSURE**

1 lb. Per sq. in.	= 3.13 ft. water at 60°F
	= 2.04 in. hg at 60°F
1 ft. water at 60°F	= .433 lb. per sq. in.
	= .884 in. hg at 60°F
1 in. Hg at 60°F	= .49 lb. per sq. in.
	= 1.13 ft. water at 60°F
1 lb. Per sq. in.	= lb. per sq. in gauge (psig)
Absolute (psia)	= 14.7

**TEMPERATURE**

$$^{\circ}\text{C} = (^{\circ}\text{F}-32) \times 5/9$$

**VOLUME**

1 gal. (U.S.)	= 128 fl. oz. (U.S.)
	= 231 cu. in.
	= .833 gal. (Brit.)
1 cu. ft.	= 7.48 gal. (U.S.)

**WEIGHT OF WATER**

1 cu. ft. at 50°F.	= 62.41 lb.
1 gal. at 50°F.	= 8.34 lb.
1 cu. ft. of ice	= 57.2 lb.
1 cu. ft. at 39.2°F.	= 62.43 lb.

Note: Water is at its greatest density at 39.2°F

**WEIGHT OF LIQUID**

1 gal. (U.S.)	= 8.34 lb. x sp. gr.
1 cu. ft.	= 62.4 lb. x sp. gr.
1 lb.	= .12 U.S. gal. / sp. gr.
	= .016 cu. ft. / sp. gr.

**WORK**

1 Btu (mean)	= 778 ft. lb.
	= .293 watt hr.
	= $\frac{1}{180}$ of heat required to change temp of 1 lb. water from 32°F to 212°F
1 hp-hr	= 2545 Btu (mean)
	= .746 kwhr
1 Kwhr	= 3413 Btu (mean)
	= 1.34 hp-hr

## GEOMETRY FORMULAS

$A = \text{AREA}$

$A_1 = \text{SURFACE AREA OF SOLIDS}$

$V = \text{VOLUME}$

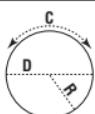
$C = \text{CIRCUMFERENCE}$

$\pi = \text{Pi} (3.14159)$

### CIRCLE

$$A = \pi \cdot R^2$$

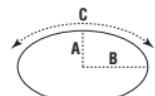
$$R = D / 2$$



### ELLIPSE

$$A = \pi \cdot A \cdot B$$

$$C = 2 \cdot \pi \sqrt{\frac{A^2 + B^2}{2}}$$



### PARALLELOGRAM

$$A = H \cdot L$$



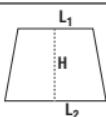
### RECTANGLE

$$A = H \cdot L$$



### TRAPEZOID

$$A = H \cdot (L_1 + L_2) / 2$$



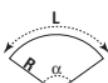
### SECTOR OF CIRCLE

$$A = (\pi \cdot R^2 \cdot \alpha) / 360$$

$$L = (\pi \cdot R \cdot \alpha) / 180$$

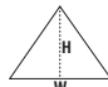
$$\alpha = (L \cdot 180) / (\pi \cdot R)$$

$$R = (L \cdot 180) / (\pi \cdot \alpha)$$



### TRIANGLE

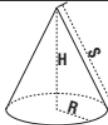
$$A = (W \cdot H) / 2$$



### CONE

$$A_1 = (\pi \cdot R \cdot S) + (\pi \cdot R^2)$$

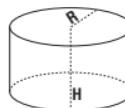
$$V = (\pi \cdot R^2 \cdot H) / 3$$



### CYLINDER

$$A_1 = (2 \cdot \pi \cdot R^2) + (2 \cdot \pi \cdot R \cdot H)$$

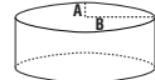
$$V = \pi \cdot R^2 \cdot H$$



### ELLiptical TANKS

$$A_1 = 2 \cdot \pi \cdot \left( A \cdot B + H \cdot \sqrt{\frac{A^2 + B^2}{2}} \right)$$

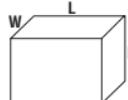
$$V = \pi \cdot A \cdot B \cdot H$$



### RECTANGULAR SOLID

$$A_1 = 2 \cdot [(W \cdot L) + (L \cdot H) + (H \cdot W)]$$

$$V = W \cdot L \cdot H$$



### SPHERE

$$A_1 = 6 \cdot \pi \cdot R^2$$

$$V = (4 \cdot \pi \cdot R^3) / 3$$



### CAPACITY IN GALLONS

For the above contains, capacity in gallons (G) is:

$G = (V / 231)$ ; when V is in cubic inches

$G = (V \cdot 7.48)$ ; when V is in cubic feet

## SPRINKLER SYSTEM FORMULAS

### Simple Flow Rate

$$Q = K \cdot P^{0.5}, \text{ where}$$

Q = flow rate (GPM)

K = discharge coefficient of pipe

P = pressure (PSI)

### General Volumetric Flow Rate

$$Q = 29.8 \cdot D^2 Cd \cdot P^{0.5}, \text{ where}$$

Q = flow rate (GPM)

D = outlet diameter (Inches)

Cd = discharge coefficient based on  
outlet geometry

P = pressure (PSI)

### Pressure Tank Sizing (Tank above sprinklers)

$$P = (30/A) - 15, \text{ where}$$

P = air pressure in tank (PSI)

A = proportion of air in the tank

### Pressure Tank Sizing (Tank below sprinklers)

$$P = (30/A) - 15 + (0.43 \cdot H/A), \text{ where}$$

P = air pressure carried in tank (PSI)

A = proportion of air in the tank

H = height of highest sprinkler above  
tank bottom (Ft)

### Pressure Tank Sizing (Hydraulically calculated)

$$Pi = [(Pf + 15)/A] - 15, \text{ where}$$

Pi = tank air pressure to use (PSI)

A = proportion of air in the tank

Pf = system pressure req'd per hydraulic  
calc. (PSI)

### Darcy-Weisbach Formula for Friction Loss

$$HL = f \cdot (L/D) \cdot (v^2/2g), \text{ where}$$

HL = friction loss (Ft)

Re = Reynolds number ( $\rho VD / \mu$ )

f = friction factor ( $f=64/Re$ )

v = water velocity (Ft/Sec)

g = gravitational constant (32.174ft/sec<sup>2</sup>)

D = pipe diameter (Ft)

L = pipe length (Ft)

### PRESSURE VELOCITY

$$Pv = 0.001123 \cdot Q^2 / D^4, \text{ where}$$

Pv = pressure velocity (PSI)

Q = flow rate (GPM)

D = internal dia. of pipe (Inches)

### Hazen-Williams Formula for Pressure Loss

$$P = (4.52 \cdot Q^{1.85}) / (C^{1.85} \cdot d^{4.87}), \text{ where:}$$

P = pressure loss (PSI) per lineal ft.

Q = flow rate (GPM)

C = friction factor of pipe (constant)

d = internal diameter of pipe (Inches)

Typical "C" values:

Unlined cast or ductile iron ..... 100

Black steel (dry sys.incl.preaction) .. 100

Black steel (wet sys.incl.deluge) ... 120

Galvanized (all) ..... 120

Plastic (listed)- all ..... 150

Cement lined cast or ductile iron .. 140

Copper tube or stainless steel ..... 150

### Hazen-Williams Formula for Pressure Loss

(in SI units)

$$P = 6.05 \cdot 10^5 \cdot Q^{1.85} / (C^{1.85} \cdot d^{4.87}), \text{ where}$$

P = pressure loss (Bars) per lineal meter

Q = flow rate (Litre/Min)

C = friction factor of pipe (constant)

d = internal diameter of pipe (mm)

## STANDARD CONVERSIONS

TO CHANGE	TO	MULTIPLY BY
Inches	Feet	0.0833
Inches	Millimeters	25.4
Feet	Inches	12
Feet	Yards	0.3333
Yards	Feet	3
Square Inches	Square feet	0.00694
Square feet	Square inches	144
Square feet	Square yards	0.11111
Square yards	Square feet	9
Cubic Inches	Cubic feet	0.00058
Cubic feet	Cubic inches	1728
Cubic feet	Cubic yards	0.03703
Cubic yards	Cubic feet	27
Cubic Inches	Gallons	0.00433
Cubic feet	Gallons	7.48
Gallons	Cubic inches	231
Gallons	Cubic feet	0.1337
Gallons	Pounds of water	8.33
Pounds of water	Gallons	0.12004
Ounces	Pounds	0.0625
Pounds	Ounces	16

TO CHANGE	TO	MULTIPLY BY
Inches of water	Pounds per square inch	0.0361
Inches of water	Inches of mercury	0.0735
Inches of water	Ounces per square inch	0.578
Inches of water	Pounds per square foot	5.2
Inches of mercury	Inches of water	13.6
Inches of mercury	Feet of water	1.1333
Inches of mercury	Pounds per square inch	0.4914
Ounces per square inch	Inches of mercury	0.127
Ounces per square inch	Inches of water	1.733
Pounds per square inch	Inches of water	27.72
Pounds per square inch	Feet of water	2.31
Pounds per square inch	Inches of mercury	2.04
Pounds per square inch	Atmospheres	0.0681
Feet of water	Pounds per square inch	0.434
Feet of water	Pounds per square foot	62.5
Feet of water	Inches of mercury	0.8824
Atmospheres	Pounds per square inch	14.696
Atmospheres	Inches of mercury	29.92
Atmospheres	Feet of water	34
Long tons	Pounds	2240
Short tons	Pounds	2000
Short tons	Long tons	0.89285

## HARDNESS CONVERSION NUMBERS

- (1) Brinell Indentation Diameter, MM.  
 (2) Standard or Tungsten Carbide Ball, Brinell Hardness No. – 10MM. Ball 3000-KG. Load  
 (3) Diamond Pyramid Hardness Number. 50-KG. Load

- (4) Rockwell Hardness Number  
 B-Scale 100-KG. Load;  $\frac{1}{16}$ " Diameter Ball  
 (5) Rockwell Hardness Number  
 C-Scale 150-KG. Load Brale Penetrator  
 Rockwell Superficial Hardness Number

- Superficial Brale Penetrator:  
 (6) 15-N Scale 15-KG. Load  
 (7) 30-N Scale 30-KG. Load  
 (8) 45-N Scale 45-KG. Load  
 (9) Shore Scleroscope Hardness Number  
 (10) Tensile Strength (Approx.) 1000 PSI.

(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)
2.95	429	455	—	45.7	83.4	64.6	49.9	61	217
3.00	415	440	—	44.5	82.8	63.5	48.4	59	210
3.05	401	425	—	43.1	82.0	62.3	46.9	58	202
3.10	388	410	—	41.8	81.4	61.1	45.3	56	195
3.15	375	396	—	40.4	80.6	59.9	43.6	54	188
3.20	363	383	—	39.1	80.0	58.7	42.0	52	182
3.25	352	372	(110.0)	37.9	79.3	57.6	40.5	51	176
3.30	341	360	(109.0)	36.9	78.6	56.4	39.1	50	170
3.35	331	350	(108.5)	35.5	78.0	55.4	37.8	48	166
3.40	321	339	(108.0)	34.3	77.3	54.3	36.4	47	160
3.45	311	328	(107.5)	33.1	76.7	53.3	34.4	46	155
3.50	302	319	(107.0)	32.1	76.1	52.2	33.8	45	150
3.55	293	309	(106.0)	30.9	75.5	51.2	32.4	43	145
3.60	285	301	(105.5)	29.9	75.0	50.3	31.2	—	141
3.65	277	292	(104.5)	28.8	74.4	49.3	29.9	41	137
3.70	269	284	(104.0)	27.6	73.7	48.3	28.5	40	133
3.75	262	276	(103.0)	26.6	73.1	47.3	27.3	39	129
3.80	255	269	(102.0)	25.4	72.5	46.2	26.0	38	126
3.85	248	261	(101.0)	24.2	71.7	45.1	24.5	37	122
3.90	241	253	100.0	22.8	70.9	43.9	22.8	36	118
3.95	235	247	99.0	21.7	70.3	42.9	21.5	35	115
4.00	229	241	98.2	20.5	69.7	41.9	20.1	34	111

(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)
4.05	223	234	97.3	(18.8)	—	—	—	—	—
4.10	217	228	96.4	(17.5)	—	—	—	33	105
4.15	212	222	95.5	(16.0)	—	—	—	—	102
4.20	207	218	94.6	(15.2)	—	—	—	32	100
4.25	201	212	93.8	(13.8)	—	—	—	31	98
4.30	197	207	92.8	(12.7)	—	—	—	30	95
4.35	192	202	91.9	(11.5)	—	—	—	29	93
4.40	187	196	90.7	(10.0)	—	—	—	—	90
4.45	183	192	90.0	(9.0)	—	—	—	28	89
4.50	179	188	89.0	(8.0)	—	—	—	27	87
4.55	174	182	87.8	(6.4)	—	—	—	—	85
4.60	170	178	86.8	(5.4)	—	—	—	26	83
4.65	167	175	86.0	(4.4)	—	—	—	—	81
4.70	163	171	85.0	(3.3)	—	—	—	25	79
4.80	156	163	82.9	(0.9)	—	—	—	—	76
4.90	149	156	80.8	—	—	—	—	23	73
5.00	143	150	78.7	—	—	—	—	22	71
5.10	137	143	76.4	—	—	—	—	21	67
5.20	131	137	74.0	—	—	—	—	—	65
5.30	126	132	72.0	—	—	—	—	20	63
5.40	121	127	69.8	—	—	—	—	19	60
5.50	116	122	67.6	—	—	—	—	18	58
5.60	111	117	65.7	—	—	—	—	15	56

## COATED ARC WELDING ELECTRODES - TYPES & STYLES

### A. W. S. CLASSIFICATION

#### E6010 Direct Current, Reverse polarity, All Positions.

All purpose. Moderately smooth finish. Good penetration. This is the electrode used for most carbon steel pipe welding.

#### E6011 Alternating Current, All Positions.

All purpose. Moderately smooth finish. Good penetration.

#### E6012 Direct Current, Straight Polarity, All Positions.

High bead. Smooth. Fast. "Cold rod".

#### E6013 Alternating Current, All Positions.

High bead. Smooth. Fast. "Cold rod".

#### E6015 Direct Current, Reverse polarity, All Positions.

"Low hydrogen" electrode.

#### E6016 Direct Current or Alternating Current, All Positions

"Low hydrogen" electrode.

#### E6018 Direct Current, All Positions.

"Low hydrogen" iron powder electrodes

#### E6020 Direct Current, Straight Polarity, Flat Position Only.

Flat bead. Smooth. Fast. Deep penetration. Can be used w/ A.C. also. "Hot rod".

#### E6024 Direct Current, Straight Polarity or Alternating and Current, and Flat Position Only. Flat bead. Smooth. Fast. Deep penetration.

#### E6027 "Iron powder electrodes".

**NOTE:** This information also applies to E70, E80, E90, and E100 Series.

The last two numbers (**in bold type**) designate the types or styles and the first two numbers the minimum specified tensile strength in 1,000 psi of the weld deposit as welded.

## PHYSICAL PROPERTIES OF E60 & E70 SERIES ELECTRODES

### TYPICAL VALUES

AWS ASTM Electrode	Tensile Strength	Yield Strength	Red. in Area Elongation	Min. %
E6010	62,000-70,000	52,000-58,000	22 to 28%	35
E6011	62,000-73,000	52,000-61,000		
E6012	68,000-78,000	55,000-65,000	17 to 22%	25

### MINIMUM VALUES

AWS ASTM Electrode	Tensile Strength	Yield Strength	Elongation
E7010	70,000	57,000	22
E7011	70,000	57,000	22
E7015	70,000	57,000	22
E7016	70,000	57,000	22
E7020	70,000	52,000	25

### WELDING AND BRAZING TEMPERATURES

Carbon Steel Welding . . . . .	2700-2790°F
Stainless Steel Welding . . . . .	2490-2730°F
Cast Iron Welding . . . . .	1920-2500°F
Copper Welding and Brazing . . . . .	1980°F
Brazing Copper-Silicon with Phosphor-Bronze . . . . .	1850-1900°F
Brazing Naval Bronze with Manganese Bronze . . . . .	1600-1700°F
Silver Solder . . . . .	1175-1600°F
Low Temperature Brazing . . . . .	1175-1530°F
Soft Solder . . . . .	200-730°F
Wrought Iron . . . . .	2700-2750°F

## TROUBLE SHOOTING ARC WELDING EQUIPMENT

**PROBLEM:** Welder will not start  
(Starter not operating)

Cause: Power circuit dead.

Remedy: Check voltage.

Cause: Broken power lead.

Remedy: Repair.

Cause: Wrong supply voltage.

Remedy: Check nameplate against supply.

Cause: Open power switches

Remedy: Close.

Cause: Blown fuses.

Remedy: Replace.

Cause: Overload relay tripped.

Remedy: Let set cool. Remove cause of overloading.

Cause: Open circuit to starter button.

Remedy: Repair.

Cause: Defective operating coil.

Remedy: Replace.

Cause: Mechanical obstruction in contactor.

Remedy: Remove.

**PROBLEM:** Welder will not start  
(Starter operating)

Cause: Wrong motor connections.

Remedy: Check connection diagram.

Cause: Wrong supply voltage.

Remedy: Check nameplate against supply.

Cause: Rotor stuck.

Remedy: Try turning by hand.

Cause: Power circuit single-phased.

Remedy: Replace fuse; repair open line.

Cause: Starter single-phased.

Remedy: Check contact of starter tips.

Cause: Poor motor connection.

Remedy: Tighten.

Cause: Open circuit in windings.

Remedy: Repair.

**PROBLEM:** Welder runs but soon stops

Cause: Wrong relay heaters.

Remedy: Renewal part recommendations.

Cause: Welder overloaded.

Remedy: Considerable overload can be carried only for a short time.

Cause: Duty cycle too high.

Remedy: Do not operate continually at overload currents.

Cause: Leads too long or too narrow in cross section.

Remedy: Should be large enough to carry welding current without excessive voltage drop.

Cause: Power circuit single-phased.

Remedy: Check for one dead fuse or line.

Cause: Ambient temperature too high.

Remedy: Operate at reduced loads where temperature exceeds 100° F.

Cause: Ventilation blocked.

Remedy: Check air inlet & exhaust openings.

## TROUBLE SHOOTING ARC WELDING EQUIPMENT, CONT'D.

**PROBLEM: Starter operates & blows fuse**

Cause: Fuse too small.

Remedy: Should be two to three times rated motor current.

Cause: Short circuit in motor connections.

Remedy: Check starter & motor leads for insulation from around & from each other

**PROBLEM: Welding arc is loud & spatters excessively**

Cause: Current setting too high

Remedy: Check setting & output with ammeter

Cause: Polarity wrong

Remedy: Check polarity, try reversing, or an electrode of opposite polarity

**PROBLEM: Welding arc sluggish**

Cause: Current too low

Remedy: Check output, & current recommended for electrode being used

Cause: Poor connections

Remedy: Check all electrode-holder, cable & ground-cable connections. Strap iron is poor ground return

Cause: Cable long or too small

Remedy: Check cable voltage drop & change cable

**PROBLEM: Touching set gives shock**

Cause: Frame not grounded

Remedy: Ground solidly

**PROBLEM: Generator control fails to vary current**

Cause: Any part of field circuit may be short circuited or open circuited

Remedy: Find faulty contact & repair

**PROBLEM: Welder starts but will not deliver welding current**

Cause: Wrong direction of rotation

Remedy: See INITIAL STARTING

Cause: Brushes worn or missing

Remedy: Check that all brushes bear on commutator with sufficient tension

Cause: Brush connections loose

Remedy: Tighten

Cause: Open field circuit

Remedy: Check connection to rheostat, resistor, & auxiliary brush studs

Cause: Series field & armature circuit open

Remedy: Check with test lamp or bell ringer

Cause: Wrong driving speed

Remedy: Check name plate against speed of motor or belt drive

Cause: Dirt, grounding field coils

Remedy: Clean & reinsulate

Cause: Welding terminal shorted

Remedy: Electrode holder or cable grounded

## TROUBLE SHOOTING ARC WELDING EQUIPMENT, CONT'D.

### PROBLEM: Welder generating but current falls off when welding

Cause: Electrode or ground connection loose

Remedy: Clean & tighten all connections

Cause: Poor ground

Remedy: Check ground-return circuit

Cause: Brushes worn worn off

Remedy: Replace with recommended grade. Sand to fit. Blow out carbon dust.

Cause: Weak brush spring pressure.

Remedy: Replace or readjust brush springs

Cause: Brush not properly fitted

Remedy: Sand brushes to fit

Cause: Brushes in backwards

Remedy: Reverse

Cause: Wrong brushes used

Remedy: Renewal part recommendations

Cause: Brush pigtails damaged

Remedy: Replace brushes

Cause: Rough or dirty commutator

Remedy: Turn down or clean commutator

Cause: Motor connection single-phased

Remedy: Check all connections

**BASIC ARC & GAS WELDING SYMBOLS**

1. In plan or elevation, near, far, and both sides, locations refer to nearest member parallel to plane of drawing and not to others farther behind.
2. In section or end views only, when weld is not drawn, the side to which arrow points is considered near side.
3. Welds on both sides are of same size unless otherwise shown.
4. Symbols govern to break in continuity of structure or to extent of hatching or dimension lines.
5. Tail of arrow used for specification reference.
6. All welds are continuous and of user's standard proportions and all except V-grooved and bevel-grooved welds are closed unless otherwise shown.
7. When welds are drawn in section or end views, obvious information is not given by symbol.
8. In joints in which one member only is to be grooved, arrows point to that member.

BASIC WELD SYMBOLS										
Back	Fillet	Plug or Slot	GROOVE OR BUTT							
			Square	V	Bevel	U	J	Flare V	Flare Bevel	

SUPPLEMENTARY WELD SYMBOLS					
Backing	Spacer	Weld All-Around	Field Weld	Flush	Contour

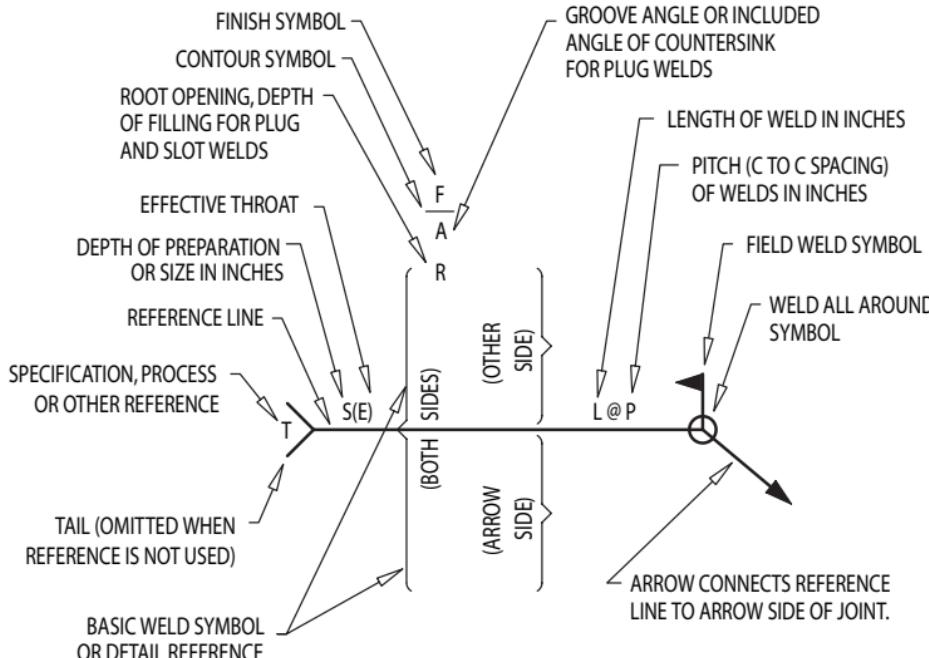
See AWS A2.4 for a detailed review of standard welding symbols

## BASIC ARC & GAS WELDING SYMBOLS, CONT'D.

### NOTE:

1. Size, weld symbol, length of weld and spacing must read in that order from left to right along the reference line. Neither orientation of reference line nor location of the arrow alter this rule.
2. The perpendicular leg of  $\triangle$ ,  $\vee$ ,  $\text{V}$ ,  $\text{VJ}$  weld symbols must be at left.
3. Arrow and other side welds are of the same size unless otherwise shown. Dimensions of fillet welds must be shown on both the arrow side and other side symbol.
4. The point of the field weld symbol must point toward the tail.
5. Symbols apply between abrupt changes in direction of welding unless governed by the "All Around" symbol or otherwise dimensioned.

### STANDARD LOCATION OF ELEMENTS OF A WELDING SYMBOL



## SYMBOLS FOR PIPE FITTINGS

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Bushing-Reducing			6 4		
Cap					
Cross (Reducing)	6 2 4 6	6 2 4 6	6 2 4 6	6 2 4 6	6 2 4 6
Cross (Straight)					
Crossover					
Elbow - 45					

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Elbow - 90					
Elbow - Turned Down					
Elbow - Turned Up					
Elbow - Base					
Elbow - Double Branch					
Elbow - Long Radius					

## SYMBOLS FOR PIPE FITTINGS

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Elbow - Reducing					
Elbow - Side Outlet (Outlet Down)					
Elbow - Side Outlet (Outlet Up)					
Elbow - Street					
Joint - Conn. Pipe					
Joint - Expansion					

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Lateral					
Orifice Plate					
Reducing Flange					
Plug - Bull					
Plug - Pipe					
Reducer - Concentric					

## SYMBOLS FOR PIPE FITTINGS

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Reducer - Eccentric					
Valve - Gate Angle Gate (Plan)					
Valve - Globe Angle Globe (Elevation)					
Valve - Globe (Plan)					
Valve (Auto)- B-Pass					
Valve (Auto)- Governor Oper.					

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Valve - Reducing					
Valve - Check (Straight Way)					
Valve - Cock					
Valve - Diaphragm					
Valve - Float					
Valve - Gate*					

## SYMBOLS FOR PIPE FITTINGS

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Valve - Gate Motor Operated					
Valve - Globe					
Valve - Globe Motor Operated					
Valve - Angle Hose Angle					
Valve - Hose Gate					
Valve - Hose Globe					

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Valve - Lockshield					
Valve - Quick Opening					
Valve - Safety					
Sleeve					

## SYMBOLS FOR PIPE FITTINGS

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Tee - Straight					
Tee - Outlet Up					
Tee - Outlet Down					
Tee - Double Sweep					
Tee - Reducing					
Tee - Single Sweep					

	Flanged	Screwed	Bell & Spigot	Welded	Soldered
Tee - Side Outlet (Outlet Down)					
Tee - Side Outlet (Outlet Up)					
Union					
Angle Valve Check					
Angle Valve Gate					

## WIRE ROPE

### OVERVIEW

Strength of wire ropes vary, depending on the material from which the individual strands are made and the method used in forming the cable, ranging between 30 and 100 tons per square inch. Primarily there are 3 classes of wire rope:

- (1) **Iron** – Iron wire is soft with low tensile strength of 30 to 40 tons per square inch. Commonly used for drum type elevator cables and to some extent for derrick guys; being replaced by low-carbon steel wire in these uses.
- (2) **Cast Steel** – May have a tensile strength up to 90 tons per square inch and because of its greater strength is generally used for hoisting purposes. To check quickly whether a piece of wire is iron or cast steel, bend it. Iron will bend easily and take a long time to regain its original shape, while cast steel will be harder to bend and will snap back to its original shape very quickly.
- (3) **Plow Steel** - Plow steel wire rope is made from high grade, open hearth furnace steel and has an average tensile strength of 110 tons per square inch. This is the best and safest wire rope for cranes, derricks, dredges and slings or straps for heavy loads.

### LUBRICATION — WIRE ROPE

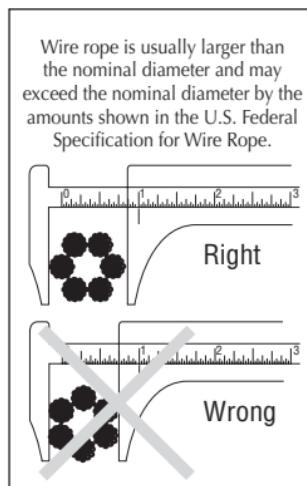
All wire rope, whether used indoors or out, should be considered as a group of moving wires constantly rubbing against one another. The resulting friction causes incessant wear on the moving parts of the wire rope or cable and will shorten its life very rapidly unless lubricants are used to overcome the friction. Lubrication also prevents rusting.

Lubricating intervals will depend on the types and amount of work encountered. Under average conditions, if worked steadily on equipment, wire rope or cable will require

lubrication once every 3 weeks. Where heavy abrasive dusts exist, more frequent lubrication is in order. Rusty ropes may break without warning.

### SHEAVES

The life of wire rope or cable is directly affected by the condition and size of the sheaves over which it is used. Sheaves should be at least 16 x the diameter of the rope or cable that is used over them. In passing over a sheave, the inside portion of the cable, which is against the sheave, is shortened and compression is developed in that section of the cable. The outside portion (away from the sheave) is lengthened or stretched, causing tension in that section. These compressive and tensional stresses combine to create bending



## WIRE ROPE

stresses which increase rapidly as the diameter of the sheaves decrease. As these bending stresses cause much undue wear and directly shorten the safe working life of the rope or cable, the ratio mention between sheaves and rope should be maintained.

New wire rope may be damaged and not work properly in sheaves that have become worn or in which the grooves have become irregular in shape. When sheaves are worn or damaged, it is more economical to renew the sheaves rather than to allow excessive wear on the cable.

One cause of very severe wear in wire rope or cables is reverse bending, which will shorten the life of the rope by approximately  $\frac{1}{2}$ . Reverse bending refers to the bending of a cable or rope over sheaves, first in one direction then in another.

Another cause of severe rope wear is twisting of the fall rope.

When the fall rope is twisted and a hoist is made, the wear produced is equal to more than that resulting from weeks of normal use. The person in charge of lifting operations should guard against twisting of the fall rope and should not allow a lift to be made if the fall rope is twisted.

No. of Crosby or Safety Clips & Dist. Between Clips Needed for Safety

Rope Dia. Inches	No. of Clips	Dist. Between Clips, Inches
$\frac{1}{4} - \frac{3}{8}$	3	$2\frac{1}{4}$
$\frac{7}{16} - \frac{5}{8}$	3	$3\frac{3}{4}$
$\frac{3}{4} - 1\frac{1}{8}$	4	$6\frac{3}{4}$
$1\frac{1}{4} - 1\frac{1}{2}$	5	9
$1\frac{5}{8} - 1\frac{3}{4}$	6	$10\frac{1}{2}$
2 and over	7	6 x diam. of cable

## HANDLING CABLE OR WIRE ROPE

Cable or wire rope must not be coiled or uncoiled like manila rope. Cable or wire rope must be taken off the reel in a straight line, avoiding kinking. The reel may be mounted on a heavy pipe or roller to facilitate unwinding. If space is limited, the cable as it comes off the reel may be layed out in a figure 8, after which it can be reeved into the line for which it is intended.

## CLAMP FASTENINGS

When it is necessary to make a short bend, as in attaching wire rope or when it is to be looped, thimbles should always be used.

In clamping a strap or an eye, the loose or "dead" end is clamped against the main part of the rope with the damps spaced apart a distance equal to  $6 \times$  diameter of the rope. Clamp fastenings seldom develop more than  $\frac{4}{5}$  of rope strength at best.

The point of greatest fatigue and/or wear in a rope usually develops at or near the end where it is clamped around the boom or where attached to the becket on the block. Clamps should be inspected at least once weekly and tightened if they show signs of loosening. All clamped or spliced fastenings, especially those on cranes or derricks, should be shifted and changed at least once every six months.

**U BOLTS OF ALL CLAMPS MUST BE ON THE DEAD END OF THE ROPE.**

## WIRE ROPE



**CORRECT** - U-Bolts on short end of rope. (No distortion on live end of rope.)



**CORRECT**

**INCORRECT** - Thimble should be used to increase strength of eye and reduce wear on rope.



**INCORRECT** - U-Bolts on live end of rope. (Causes mashed spots on live end of rope.)



**INCORRECT** - Staggered clips. (Causes a mashed spot in live end of rope due to incorrect position of center clip.)



**INCORRECT** - Wire rope knot with clip efficiency 50% or less



### SAFE LOAD (IN POUNDS) ON IMPROVED PLOW STEEL WIRE ROPE (6 Strands, 19 or 37 Wires per Strand, Hempcore)

Dia. In.	Circum. In.	Single Vertical Wirerope	TWO PART SLING			Breaking Strength	
			60°	45°	30°	Wt./Ft. Lbs.	Tons (2000 lbs)
1/4	3/4	1,100	1,900	1,550	1,100	0.10	2.74
3/8	1 1/8	2,500	4,230	3,460	2,450	0.23	6.1
1/2	1 1/2	4,300	7,450	6,080	4,300	0.40	10.7
5/8	2	6,600	11,600	9,430	6,670	0.63	16.7
3/4	2 1/4	9,400	16,500	13,450	9,520	0.90	23.8
7/8	2 3/4	12,800	22,300	18,200	12,800	1.23	32.2
1	3	16,000	29,000	23,690	16,790	1.60	41.8
1 1/8	3 1/2	21,000	36,450	29,780	21,040	2.03	52.6
1 1/4	4	26,000	44,700	36,570	25,870	2.50	64.6
1 3/8	4 1/4	31,000	53,800	43,900	31,050	3.03	77.7
1 1/2	4 3/4	37,000	63,700	52,000	36,800	3.60	92.0
1 5/8	5	43,000	74,400	60,700	42,900	4.23	107.0
1 3/4	5 1/2	49,600	86,000	70,260	49,700	4.90	124.0
2	6 1/4	64,000	110,700	90,400	64,000	6.40	160.0
2 1/8	6 5/8	63,000	125,200	102,200	72,200	7.22	181.0
2 1/4	7 1/8	81,000	140,300	114,600	79,000	8.10	202.0
2 1/2	7 7/8	98,000	170,000	139,100	98,400	10.00	246.0
2 3/4	8 5/8	117,600	203,500	166,700	117,700	12.10	294.0



## GRUVLOK® LUBRICANTS

### GRUVLOK® XTREME™ LUBRICANT

Gruvlok® Xtreme™ Lubricant has been developed for use with Gruvlok couplings in services where improved lubrication is beneficial. This lubricant has an operating temperature range from -65°F to 400°F, well exceeding the temperature range of Gruvlok gaskets. This lubricant is waterproof, thereby eliminating water wash-out and it will not dry out in the absence of water. There are five primary applications where the Xtreme Lubricant will provide increased benefits: low temperature applications (below -20°F), high temperature applications (above 150°F), applications where increased pipe joint flexibility is needed, lubrication of gaskets in copper systems, and for the lubrication of gaskets on HDPE couplings. Since it is formulated from a non-hydro carbon base, it can be used with EPDM, Nitrile and Fluoroelastomer gasket materials. **It is not to be used with Silicone gaskets.**

- In low temperature applications the gasket will shrink, thereby lowering the sealing force on the gasket sealing lips. The temperature change will also force the gasket to slightly re-position itself. This will cause pipe end sealing surfaces, with small cuts or damage, to become more susceptible to leakage. Gruvlok Xtreme Lubricant will maintain its lubricating properties at lower temperatures allowing a properly lubricated pipe end and gasket (assembly) to re-position itself during temperature cycles.
- For high temperature service and copper systems, it is required that the gasket be lubricated not only on the outside, as with the



NSF

Certified to  
ANSI/NSF 61

normal installation of a Gruvlok gasket, but also on the inside. Lubrication on the inside of the gasket is easily accomplished by turning the gasket inside out and applying the lubricant. Gruvlok Xtreme Lubricant will maintain its lubricating properties at higher temperatures, allowing a properly lubricated pipe end and gasket assembly to re-position itself during temperature cycles. Lubrication of the pipe end and gasket will help the gasket to adjust into the proper sealing position during temperature cycles. The lubricant on the interior of the gasket will act to improve the chemical resistance of the gasket material by providing a thin lubricant barrier between the piping system fluid and the gasket surface. This is particularly important at higher temperatures where oxidizing agents in the piping system become more aggressive. **However, gasket chemical compatibility must still be considered.**

## GRUVLOK® LUBRICANTS, CONT'D.

### GRUVLOK® XTREME™ LUBRICANT (CONT'D)

- The Gruvlok Xtreme Lubricant has been formulated from low viscosity, non-petroleum based oils to ease spreading of the lubricant. In applications where pipe movement is expected, proper lubrication of the gasket's exterior assists the gasket into the proper sealing position as pipe system movement occurs. This lubricating film enhances our flexible coupling gasket's ability to compensate for axial, transverse and rotational pipe movements.
- Gruvlok Xtreme Lubricant is the only Gruvlok lubricant that is to be used with Gruvlok couplings and gaskets in HDPE and copper piping systems. It's low temperature capability and lubricity ensure a highly reliable connection.

Gruvlok® Xtreme™ Lubricant is a Teflon® fortified white, tasteless and odorless grease made from Silicone Oil and other ingredients that are safe to ingest. It is sanctioned by the FDA under C.F.R. 21.172.878 & 21.177.1550 (Incidental Food Contact). It is NSF approved for use with potable water.

**CAUTION:** Silicone based lubricants are not allowed in some facilities.  
®Teflon is a registered trademark of Dupont.

### GRUVLOK® QUICK DRY LUBRICANT

Gruvlok® Quick Dry Lubricant is a fast drying lubricant that has been developed for applications where the piping system is exposed. The service temperature range for this lubricant is from 0° F to 150° F and may be used with all Gruvlok gasket material grades. The lubricant is made from a water emulsion that is non-toxic, it will not impart taste or odor, and does not support bacterial growth. Gruvlok Quick Dry Lubricant is non-corrosive, non-flammable, and is NSF approved for use with potable water.

This lubricant is easy to apply by brush or hand, and it quickly dries to a thin film when in contact with air. It is water-soluble. The quick drying quality of the lubricant eliminates lubricant drips caused by over lubrication. If necessary, reapply lubricant prior to assembly. Do not thin or mix with solvents.

### GRUVLOK® LUBRICANT

Gruvlok® Lubricant is the standard lubricant that has been provided for use with Gruvlok products for years. Gruvlok Lubricant is water soluble, non-toxic, non-corrosive, non-flammable, and will not impart taste or odor. It is NSF approved for use with potable water. This lubricant is acceptable for most applications, however, the Gruvlok Xtreme Lubricant and Gruvlok Quick Dry Lubricant are now available to improve the performance of the couplings and flanges in certain applications.

**CAUTION:** HDPE pipe requires the use of Gruvlok Xtreme Lubricant and should not be used with Gruvlok Lubricant

## DESIGN FACTORS

### MOVEMENT:

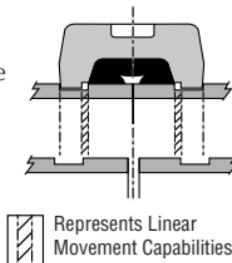
Each flexible design Gruvlok coupling can provide for pipe system movement up to the design maximum for the specific size and type coupling being utilized. Movement is possible in the Gruvlok coupling due to two factors: (1) designed-in clearance between the key of the coupling and the groove diameter and groove width, and (2) the gap between pipe ends joined by the coupling.

### LINEAR MOVEMENT:

#### FLEXIBLE COUPLING LINEAR MOVEMENT

Linear movement is accommodated within the coupling by allowing the pipe ends to move together or apart in response to pressure thrusts and temperature changes. The available linear movement provided by Standard Gruvlok couplings is shown below:

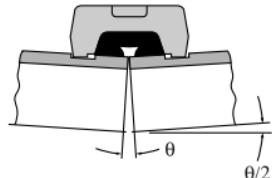
LINEAR MOVEMENT		
Sizes	Roll Groove Pipe	Cut Groove Pipe
1" thru 3½"	1/16"	1/16"
4" thru 24"	3/32"	3/16"



### ANGULAR MOVEMENT:

#### FLEXIBLE COUPLING ANGULAR MOVEMENT

Designed-in clearances allow limited deflection of the pipe joint within the coupling, without introducing eccentric loads into the coupling joint.



The maximum available angular movement of Gruvlok coupling joints is shown in the performance data for each coupling type. The amount of angular flexibility varies for each coupling size and type. For design purposes the published figures should be reduced by the below listed factors to account for pipe, groove and coupling tolerances.

Sizes	ANGULAR MOVEMENT	
	Design Factor Roll Groove	Design Factor Cut Groove
1" thru 3½"	Reduce 50%	Reduce 50%
4" thru 24"	Reduce 50%	Reduce 25%

### RIGID COUPLINGS

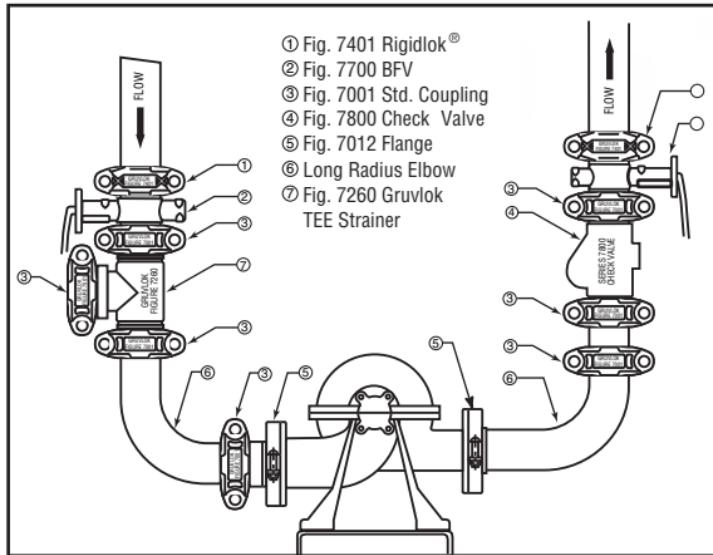
Gruvlok rigid couplings Fig. 7400, Fig. 7401 and Fig. 7004 HPR are designed to provide a joint with the attributes of a welded or flanged connection. Therefore, these joints would remain in strict alignment and would resist deflection and linear movement during service.

### FLEXIBLE COUPLINGS

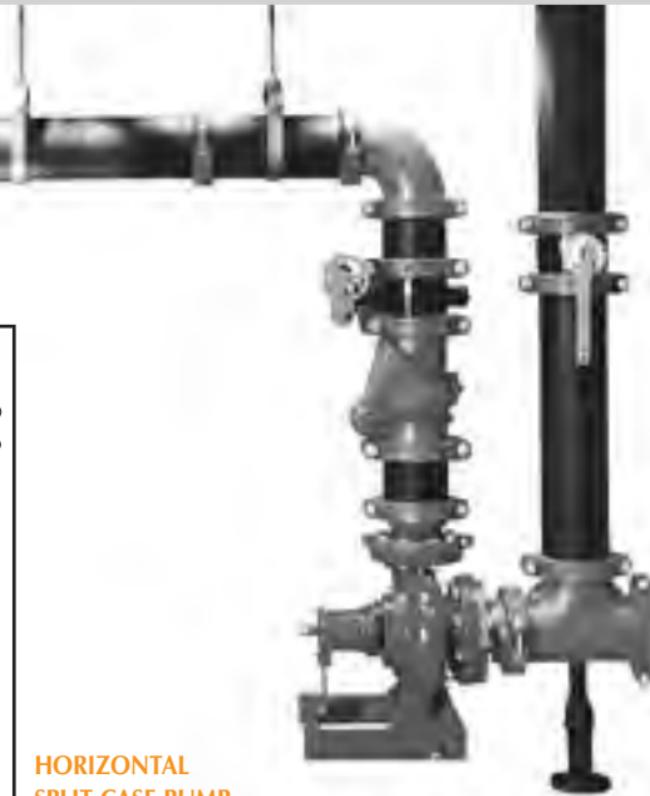
Figs. 7000, 7001, 7003, 7010 are the flexible couplings provided in the Gruvlok product line. The information above on movement applies to these flexible couplings.

**GRUVLOK® FLOW CONTROL COMPONENTS**

Anvil has put together a complete array of Gruvlok components necessary to provide pump protection for HVAC and industrial piping needs. With the combination of the Fig. 7401 Rigidlok and Fig. 7001 Standard coupling, flex connectors can be eliminated thus reducing cost. The Series 7700 Gruvlok® Butterfly valve has superior flow characteristics. The Gruvlok® Series 7800 Check Valve is full waterway valve and can be stacked directly to the Series 7700 Butterfly Valve. The Fig. 7250 Suction Diffuser and Fig. 7260 Tee Strainer complete the Gruvlok® pump protection package

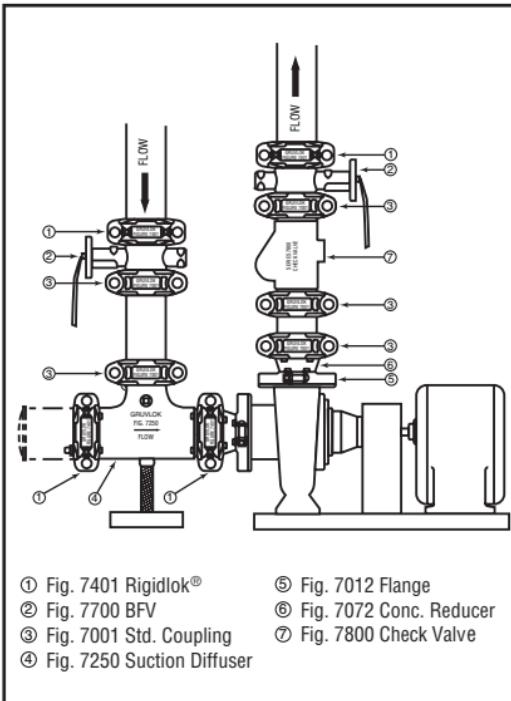


HORIZONTAL  
SPLIT CASE PUMP

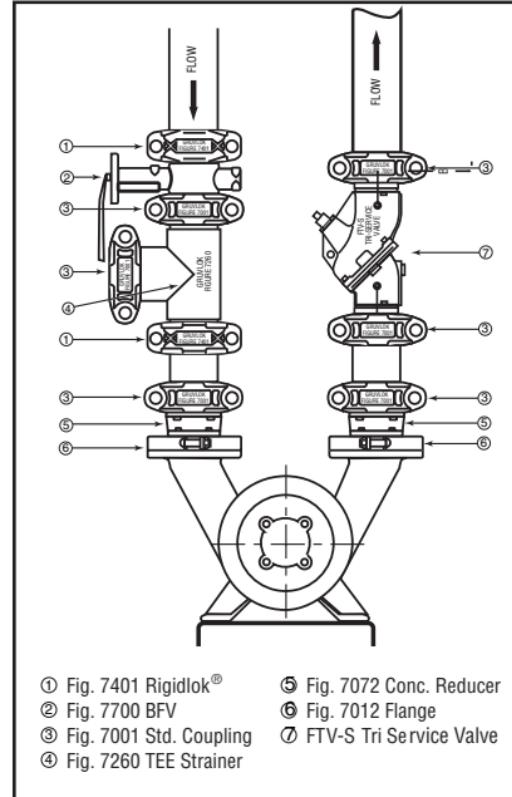


## GRUVLOK® FLOW CONTROL COMPONENTS

## END SUCTION PUMP



## VERTICAL SPLIT CASE PUMP

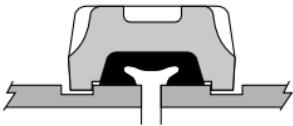


## GRUVLOK® GASKET STYLES

Gruvlok offers a variety of pressure responsive gasket styles. Each serves a specific function while utilizing the same basic sealing concept. Proper installation of the gasket compresses the inclined gasket lips on the pipe O.D., forming a leak-tight seal. This sealing action is reinforced when the gasket is encompassed and compressed by the coupling housings. The application of internal line pressure energizes the elastometric gasket and further enhances the gasket sealing action.

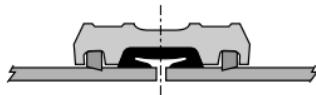


### "C" STYLE



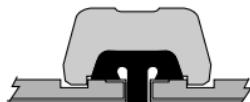
The "C" Style cross section configuration is the most widely used gasket. It is the gasket style provided as standard in many Gruvlok Couplings (Fig. 7000, 7011, 7001, 7003, 7004HPR, 7307, 7400 and 7401). Grade "E" and "T" are standard grades while other grades are available for special applications.

### ROUGHNECK®



This "C" style gasket is similar in appearance and design to the Standard gasket but is only used with Fig. 7005 Roughneck Couplings and Fig. 7305 HDPE Couplings. The Roughneck gasket is wider, which allows for minor pipe end separation as line pressure sets the grippers into the plain end pipe.

### END GUARD®

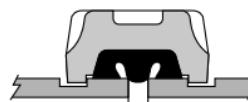


The projecting rib fits between the ends of lined pipe to prevent damage to unprotected pipe ends during coupling joint assembly.

The E.G. gasket is provided as standard with the Fig. 7004 E.G. Coupling.

Grade "E" and "T" gaskets are available.

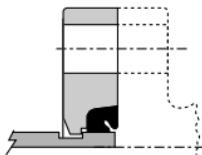
### FLUSH GAP®



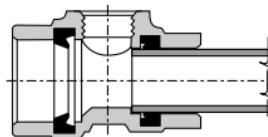
Designed to prohibit contaminants from building up in the gasket cavity. The centering rib fits flush over the gap between the two pipe ends thus closing off the gasket cavity. It can be used with Fig. 7000, 7001, 7003, 7004, 7400 and 7401 Couplings for many applications. Recommended for use in dry fire protection systems. Not recommended for temperatures above 160°F.

**GRUVLOK® GASKET STYLES****REDUCING COUPLING**

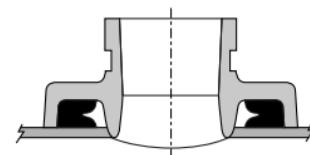
The centering rib allows for pipe positioning and serves to keep the smaller pipe from telescoping during installation. Used only with the Fig. 7010 Reducing Coupling.

**FLANGE**

A specially designed gasket for the Fig. 7012, 7013 and 7312 Flange provides for a reliable seal on both the pipe and the mating flange.

**SOCK-IT®**

Used in Sock-It fittings only, this pressure energized gasket provides a leak-tight seal on plain end seal pipe. Available in Grade "E" material only.

**CLAMP-T®**

These gaskets conform to the curved exterior of the pipe to provide a pressure responsive seal. This unique design is only used with Fig. 7045, 7046 Clamp-T and Fig. 7047, 7048, and 7049 Clamp-T Crosses.

**VACUUM SERVICE**

VACUUM SERVICE		
Size	Vacuum Level	Gasket Recommendation
1" - 6"	0" - 29.92" Hg	Standard or Flush Gap
8" - 12"	0" - 15 Hg	Standard or Flush Gap
1½" - 12"	0" - 29.92 Hg	Flush Gap

**LARGER SIZES:** Contact a Anvil Representative for more information.

**GASKET GRADE INDEX & GASKET RECOMMENDATION**

The lists are provided as an aid in selecting the optimum gasket grade for a specific application to assure the maximum service life.

The recommendations have been developed from current information supplied by manufacturers of the elastomers, technical publications, and industry applications. The information supplied should be considered as a basis for evaluation but not as a guarantee.

Selection of the optimum gasket grade for a specific service requires the consideration of many factors; primarily temperature, fluid concentration, and continuity of service. Unless otherwise noted, all gasket recommendations are based on 100°F (38°C) maximum temperature service condition. Where more than one gasket grade is shown, the preferred grade is listed first.

Combinations of fluids should be referred to a Anvil Representative for an engineering evaluation and recommendation. In unusual or severe services, gasket materials should be subjected to simulated service conditions to determine the most suitable gasket grade.

Gasket recommendations apply only to Gravlok gaskets. Contact a Anvil Representative for recommendations for services not listed. These listings do not apply to Gravlok Butterfly Valves.

All Gravlok products marked with UL/ULC Listed, FM approved VdS and/or LPC symbols are Listed/Approved with EPDM material. For other Listed/Approved materials, please contact a Anvil Representative for more information.

**GASKET GRADE INDEX**

STANDARD GASKETS				
Grade	Temp. Range	Compound	Color Code	General Service Applications
E	-40°F to +230°F	EPDM	Green	Water, dilute acids, alkalies, salts, & many chemical services not involving hydrocarbons, oils, or gases. Excellent oxidation resistance.  <b>NOT FOR USE WITH HYDROCARBONS</b>
T	-20°F to +180°F	Nitrile (Buna-N)	Orange	Petroleum products, vegetable oils, mineral oils, & air contaminated with petroleum oils.  <b>NOT FOR USE IN HOT WATER SERVICES</b>

SPECIAL GASKETS				
Grade	Temp. Range	Compound	Color Code	General Service Applications
O	+20°F to +300°F	Fluoro Elastomer	Blue	High temperature resistance to oxidizing acids, petroleum oils, hydraulic fluids, halogenated hydrocarbons & lubricants.
L	-40°F to +350°F	Silicone	Red Gasket	Dry, hot air & some high temperature chemical services.
E Type A	-40°F to +150°F		Violet	Wet & Dry (oil free air) Pipe in Fire Protection Systems. For dry pipe systems, Gravlok Xtreme™ Temperature Lubricant is required.

**GASKET GRADE INDEX & GASKET RECOMMENDATION****GASKET RECOMMENDATION LISTING**

WATER & AIR	
Service	Gasket Grade
Air, (no oil vapors) Temp. -40°F to 230°F (-40°C to 110°C)	E
Air, (no oil vapors) Temp. -40°F to 350°F (-40°C to 177°C)	L
Air, Oil vapor Temp. -20°F to 150°F (-29°C to 66°C)	T
Air, Oil vapor Temp. 20°F to 300°F (-7°C to 149°C)	O
Water, Temp to 150°F (66°C)	E/T
Water, Temp to 230°F (110°C)	E
Water, Acid Mine	E/T
Water, Chlorine	(E/O)
Water, Deionized	E/T
Water, Seawater	E/T
Water, Waste	E/T
Water, Lime	E/T

Where more than one gasket grade is shown the preferred gasket grade is listed first. Where the gasket grade is shown in parentheses, Contact a Anvil Representative for an engineering evaluation and recommendation. Specify gasket grade when ordering. Use Gruvlok lubricant on gasket. Check gasket color code to be certain it is recommended for the service intended.

PETROLEUM PRODUCTS	
Service	Gasket Grade
Crude Oil - Sour	T
Diesel Oil	T
Fuel Oil	T
Gasoline, Leaded	T
Gasoline, Unleaded*	(O)
Hydraulic Oil	T
JP-3, JP-4 and JP-5	T/O
JP-6, 100°F (38°C) Maximum Temp.	O
Kerosene	T
Lube Oil, to 150°F (66°C)	T
Motor Oil	T
Tar and Tar Oil	T
Transmission Fluid --Type A	O
Turbo Oil #15 Diester Lubricant	O

Unless otherwise noted, all gasket listings are based upon 100°F (38°C) maximum temperature service conditions. For services not listed Contact a Anvil Representative for recommendation. \*Contact a Anvil Representative for service evaluation.

## COUPLING DATA CHART NOTES

COUPLING DATA CHART NOTES														
Nominal Size	O.D.	Max. Wk. Pressure	Max. End Load	Range of Pipe End Separation	Deflection from CL		Coupling Dimensions			Coupling Bolts		Specified Torque		Approx. Wt. Ea.
					Per Coupling	Per in./ft.	X	Y	Z	Qty.	Size	Min.	Max.	
In./DN(mm)	In./mm	PSI/bar	Lbs./kN	In./mm	Degrees	mm/m	In./mm	In./mm	In./mm		In./mm	Ft.-Lbs/N-M	Lbs./Kg	
1	2	3	4	5	6		7			8		9	10	

1 Gruvlok Couplings are identified by either the nominal ANSI pipe size in inches or pipe O.D. in millimeters (see column 2).

2 Nominal Outside Diameter of Pipe.

3 Maximum line pressure, including surge, to which a joint can be subjected. Working pressure ratings are based on standard wall steel pipe with standard cut or roll grooves in accordance with Gruvlok specifications. For Performance Data on other than standard wall pipe, refer to Technical data section.

**NOTE:** For one time field test only the maximum joint working pressure may be increased to 1.5 times the figure shown.

4 Maximum end load from all interior and/or exterior forces to which the joint can be subjected are based on standard wall steel pipe with standard cut or roll grooves in accordance with Gruvlok specifications.

5 Range of pipe end separation is the gap between the pipe ends due to assembly.

6 Maximum allowable angular deflection of pipe from centerline when using standard cut grooved steel pipe. For details see design factors in Gruvlok Technical data section.

7 "X", "Y", and "Z" are external dimensions for reference purposes only.

8 The quantity of bolts equals the number of housing segments per coupling.

9 Nuts must be tightened alternating and evenly to the specified bolt torque. See individual product installation instructions for additional important information.

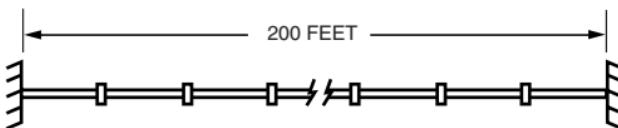
10 Approximate weight for a fully assembled coupling with gasket, bolts, and nuts.

## THERMAL MOVEMENT:

A sufficient amount of coupling joints must be provided to accommodate the calculated movement (expansion or contraction) in a pipe run or segment thereof.

### EXAMPLE:

A 200 foot long straight run of 4" steel cut grooved pipe between anchor points. Minimum Temperature: 40°F. (at time of installation). Maximum Oper. Temperature: 160°F.



Thermal expansion tables show this system will expand a total of 1.80" due to the temperature change.

### DESIGN QUESTION:

How many couplings are required to account for the thermal growth?

### AVAILABLE LINEAR MOVEMENT PER FLEXIBLE COUPLING:

Using the table on the page 257, we see that there is 0.188" linear movement per coupling (4" Flexible Coupling)

## COUPLINGS REQUIRED

As indicated above, the total movement is 1.80". Thus, the number of couplings is determined as follows:

$$\text{No. of Couplings} = \text{Tot. Movement} / \text{Avail. Movement per Coupling}$$

### FOR OUR EXAMPLE:

$$\text{No. of Couplings} = (1.80") / (0.187") = 9.6,$$

Therefore 10 couplings are needed

## POSITION OF COUPLINGS

In order for the couplings to provide for the movement indicated by the above example, it would be necessary to install all couplings with the maximum gap between pipe ends. Conversely, if the thermal movement was contraction due to a reduction of system temperature, the coupling joints would have been installed with the pipe ends butted, thus accommodating the "shrink" of the pipe system.

In either case the pipe run in question would have to be anchored at the proper locations to direct pipe system expansion or contraction into the coupling joints.

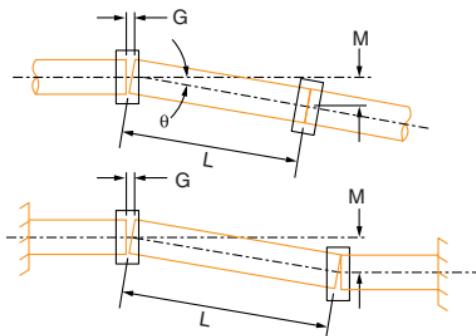
As can be seen from the above example, the pipe end gap within the coupling joint must be considered when designing a grooved-end pipe system to accommodate thermal movement. The couplings do not automatically provide for expansion and contraction of piping.

## MOVEMENT—APPLICATIONS, CONT'D.

### MISALIGNMENT & DEFLECTIONS:

The angular movement capability of the Gravlok coupling permits the assembly of pipe joints where the piping is not properly aligned. At least two couplings are required to provide for lateral pipe misalignment. Deflection (longitudinal misalignment) may be accommodated within a single coupling as long as the angle of deflection does not exceed the value shown in the coupling performance data for the particular size and coupling type.

A pipe joint that utilizes the angular deflection capability of the Gravlok coupling will react to pressure and thermal forces dependent upon the manner in which it is restrained. An unrestrained joint will react to these forces by straightening, thus reducing, if not eliminating, the deflection at the joint. If joint deflection has been designed into the pipe layout and must be maintained, then sufficient anchors must be provided to resist the lateral forces and hold the joint in the deflected condition.



The amount of deflection from pipe run centerline can be calculated utilizing the following equations:

$$M = L (\sin \theta)$$

$$\theta = \text{ArcSin} (G/D)$$

$$M = (G \times L)/D$$

#### WHERE:

M = Misalignment (inches)

G = Maximum Allowable Pipe End Movement (Inches) as shown under "Performance Data" (Value to be reduced by Design Factor)

θ = Maximum Deflection (Degrees) from centerline as shown under "Performance Data" (Value to be reduced by Design Factor)

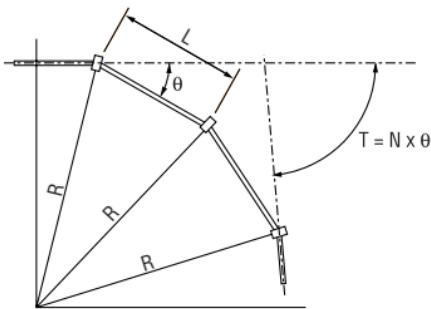
D = Pipe Outside Diameter (Inches)

L = Pipe Length (Inches)

## MOVEMENT—APPLICATIONS, CONT'D.

### CURVE LAYOUT:

Utilizing the angular deflection at each coupling joint curves may be laid out using straight pipe lengths and Gruvlok Couplings.



This example shows how to calculate the curve radius, required pipe lengths, and number of required couplings.

$$R = L / (2 \times \sin(\theta/2))$$

$$L = 2 \times R \times \sin(\theta/2)$$

$$N = T / \theta$$

### WHERE:

N = Number of Couplings

R = Radius of Curve (feet)

L = Pipe Length (feet)

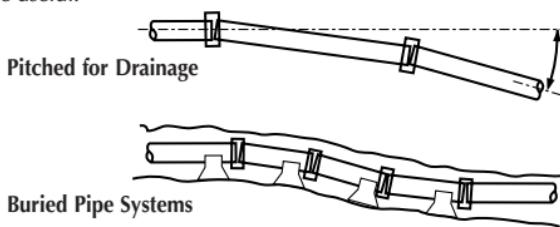
$\theta$  = Deflection from centerline (Degrees) of each Coupling  
(See coupling performance data, value to be reduced by Design Factor)

T = Total Angular Deflection of all Couplings.

### DRAINAGE, BURIED SYSTEMS, ETC.:

The flexible design of the Gruvlok coupling makes it ideal for use in a wide variety of systems in which random changes of the pipe direction can be accommodated by the Gruvlok coupling's angular deflection capability rather than requiring the use of special fittings.

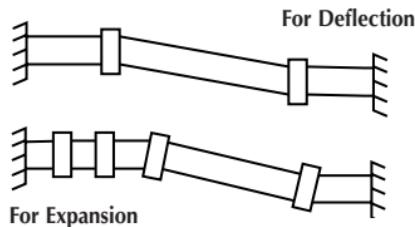
Pitched drainage systems, buried pipe systems where pipe laying conditions are subject to settlement, and exposed pipe systems laid on rough ground are but a few of the many types of pipe installations that present conditions where the functional capability of the Gruvlok coupling are useful.



### COMBINED LINEAR & ANGULAR MOVEMENT:

The clearance in the grooved coupling joint, will allow a limited capability for combined linear and angular movement. A partially deflected joint will not provide full linear movement capability. A fully deflected coupling joint provides no linear movement capability. The Gruvlok coupling will not allow for both maximum linear and maximum angular movement simultaneously.

In systems where both are expected, additional joints may be required.



#### NOTE: Fully Deflected Joint Will Not Allow For Linear Expansion.

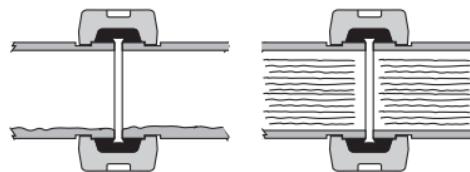
In the example above, two couplings were added to account for thermal expansion and the other couplings accommodate only the misalignment.

The additional stress from the combined movement is therefore relieved.

### ROTATIONAL MOVEMENT:

Piping systems designed with Gruvlok Couplings can accommodate minor rotational movement from thermal expansion, settlement, vibration, or other similar movements. However, Gruvlok Couplings **should never be used as a continuous swivel joint**.

#### EXAMPLE:



Before Pipe Rotation

After Pipe Rotation

Utilizing the rotational capability of the Gruvlok Coupling, the pipe life of a slurry or similar coarse material piping system can be extended.

For pipe rotation, the system must be shut down and internal pressure relieved.

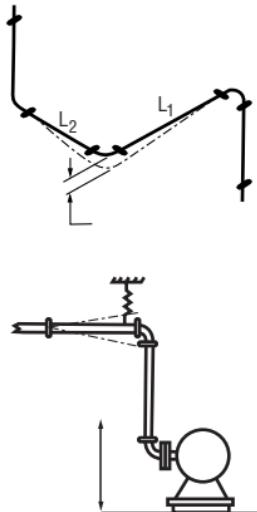
The pipe may then be rotated one-quarter turn, the couplings retightened, and service resumed. If performed on a regular basis, pipe rotation will evenly distribute wear over the entire inner surface of the pipe.

## COUPLING FLEXIBILITY

The grooved coupling's capability to allow angular and rotational movement within the coupling joint must be considered when deciding hanger and support locations. Spring hangers and supports providing for movement in more than one plane are often used to allow the pipe system to move without introducing additional stress into the pipe system.

### EXAMPLE 1

This example demonstrates the need for each pipe length in a grooved system to be supported. The sag due to the flexibility of the Gruvlok joint could be eliminated with the proper positioning of hangers on both pipe segments "L1" and "L2".



### EXAMPLE 2

This illustrates the effect of pump oscillation on a piping system. A spring hanger should be used to support the pipe section and also respond to the induced vibrations. The couplings in the horizontal run above the riser, should accommodate the deflection without transmitting bending stresses through the pipe system.

## PRESSURE THRUSTS:

Gruvlok couplings react to the application of system pressure and restrain the pipe ends from separation due to the pressure force. However, the coupling joint may not be in the self-restraining configuration prior to the application of system pressure. The Gruvlok coupling does not restrain adjacent pipe sections from separation due to pressure forces until the coupling key sections engage the groove walls.

Random flexible coupling joint installation will produce installed coupling conditions ranging from pipe ends full butted to fully separated to the maximum available gap. Thus, only after system pressurization will the self-restraining function of the coupling be in effect.

The designer must account for the movement to be encountered when the system is pressurized and the joints are fully separated. Anchor and guide positions must be defined to direct the pipe joint movement that it is not detrimental to the pipe system.

## COUPLING FLEXIBILITY, CONT'D.

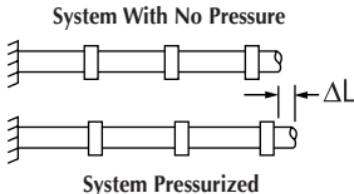
Examples of the effect of pressure thrust are shown in the following illustrations.

**EXAMPLE 1**

The coupling joints have been installed butted or partially open. When pressurized the pipe ends in the coupling joints will separate to the maximum amount permitted by the coupling design.

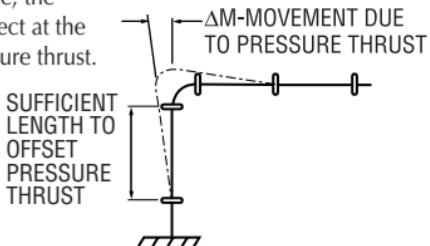
The coupling key sections will make contact with the groove walls and restrain the pipe from further separation.

The movement at each coupling joint will add with all other joints and produce  $\Delta L$ .

**EXAMPLE 2**

In the system shown here, the pipe will move and deflect at the elbow joint due to pressure thrust.

The pipe designer must assure himself that the system has the capability of deflecting sufficiently to absorb this movement without

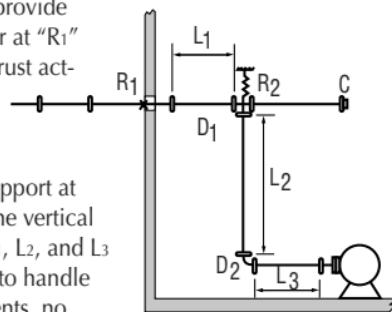


introducing additional stresses into the pipe system. In the deflected condition shown, temperature increases would produce further expansion of the pipe system thus increasing the deflection.

**EXAMPLE 3**

To restrain this system provide a pressure thrust anchor at "R<sub>1</sub>" to resist the pressure thrust acting through the tee "D<sub>1</sub>" at the cap "C". Provide a hanger at Point "R<sub>2</sub>", or a base support at Point "D<sub>2</sub>" to support the vertical column. If the offsets L<sub>1</sub>, L<sub>2</sub>, and L<sub>3</sub> are of adequate length to handle expected pipe movements, no additional anchoring is required.

Thermal movement of the pipe system should also be considered, and intermediate anchors located as required, to direct the pipe movement so as to prevent introducing bending stresses into the system.

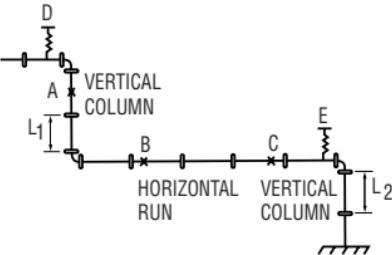


## COUPLING FLEXIBILITY, CONT'D.

### EXAMPLE 4

Anchor at "A" to support weight of vertical water column. Use spring hanger at "D" and "E" to allow movement of vertical piping.

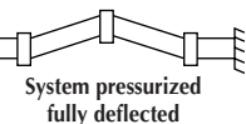
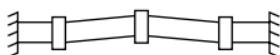
Anchors at "B" and "C" if offsets at L1 and L2 are insufficiently long to handle expected pipe movements.



### LATERAL RESTRAINT

### EXAMPLE 5

**System with no pressure partially deflected**



**System pressurized fully deflected**

A grooved coupling joint installed in a partially deflected condition between anchor locations will deflect to its fully deflected condition when pressurized. Hangers and supports must be selected with consideration of the hanger's capability to provide lateral restraint.

Light duty hangers, while acceptable in many installations, may deflect against the application of lateral forces and result in "snaking" conditions of the pipe system.

### RISER DESIGN:

Risers assembled with Gruvlok Flexible couplings are generally installed in either of two ways. In the most common method, the pipe ends are butted together within the coupling joint. Note that when installing risers, the gasket is first placed onto the lower pipe and rolled back away from the pipe end prior to positioning the upper pipe. Anchoring of the riser may be done prior to pressurization with the pipe ends butted or while pressurized, when, due to pressure thrust, the pipe ends will be fully separated.

An alternative method or riser installation is to place a metal spacer of a predetermined thickness, between the pipe ends when an additional length of pipe is added to the riser stack. The upper pipe length is anchored, the spacer removed and the coupling is then installed. This method creates a predetermined gap at each pipe joint which can be utilized in pipe systems where thermal movement is anticipated and in systems with rigid (threaded, welded, flanged) branch connections where shear forces due to pressure thrust could damage the rigid connections.

The following examples illustrate methods of installing commonly encountered riser designs.

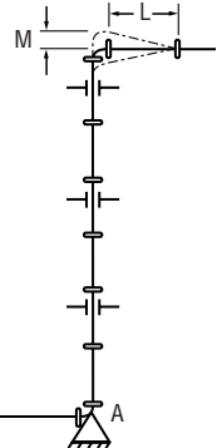
## COUPLING FLEXIBILITY, CONT'D.

**RISERS WITHOUT BRANCH CONNECTIONS**

Install the riser with the pipe ends butted.

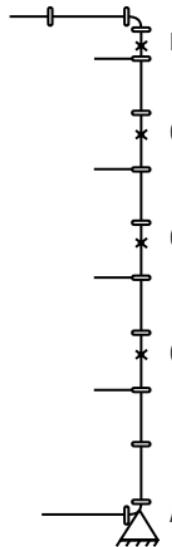
Locate an anchor at the base of the riser (A) to support the total weight of the pipe, couplings and fluid. Provide pipe guides on every other pipe length, as a minimum, to prevent possible deflection of the pipe line at the coupling joints as the riser expands due to pressure thrust or thermal growth. Note that no intermediate anchors are required.

When the system is pressurized the pipe stack will "grow" due to pressure thrust which causes maximum separation of pipe ends within the couplings. The maximum amount of stack growth can be predetermined (see Linear Movement). In this example the pipe length "L" at the top of the riser must be long enough to permit sufficient deflection (see Angular Movement) to accommodate the total movement "M" from both pressure thrust and thermal gradients.

**RISERS WITH BRANCH CONNECTIONS**

Install the riser with the predetermined gap method. Anchor the pipe at or near the base with a pressure thrust anchor "A" capable of supporting the full pressure thrust, weight of pipe and the fluid column. Anchor at "B" with an anchor capable of withstanding full pressure thrust at the top of the riser plus weight of pipe column. Place intermediate anchors "C" as shown, between anchors "A" and "B". Also place intermediate clamps at every other pipe length as a minimum.

When this system is pressurized, the pipe movement due to pressure thrust will be strained and there will be no shear forces acting at the branch connections.



## PIPE PREPARATION

To create a Gruvlok pipe joint, all pipe must be prepared to receive Gruvlok coupling or other Gruvlok pipe system components. The required pipe preparation may be grooving or cleaning the pipe ends, or cutting a hole in the pipe wall.

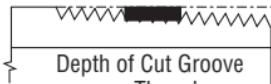
For grooved-end joints, pipe may be grooved by either of two methods; cut or roll grooving. Branch outlet connections require a properly sized and correctly located hole to be cut into the pipe. Sock-it connections require cleaning of the pipe end. Gruvlok plain-end pipe couplings

### CUT GROOVING:

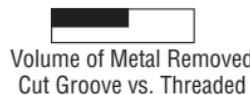
Cut grooving is intended for use with standard and heavier wall pipe. Cut grooving produces a groove in the pipe wall by removing metal from the pipe O.D. The groove removes less than one half of the pipe wall and does not cut as deeply into the pipe wall as do standard pipe threads. The square cut edge of the groove allows for the full expansion, contraction, and deflection capabilities of the Gruvlok coupling.



Cut Grooving



Depth of Cut Groove  
vs. Thread



Volume of Metal Removed  
Cut Groove vs. Threaded

require that the pipe be free of burrs and other sharp projections which could damage the gasket; grooving is not required.

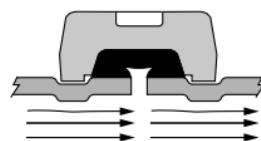
Gruvlok pipe grooving and hole cutting machines are available in a wide variety of designs to meet specific or general requirements. Anvil Roll grooving machines produce a groove to proper dimensional tolerances, concentric with the pipe O.D., even on out-of-round pipe. Gruvlok hole cutting tools properly center holes for correct assembly of Gruvlok branch outlet components.

### ROLL GROOVING:

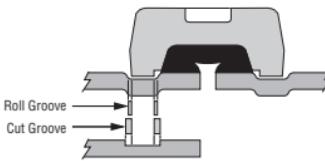
Roll grooving does not remove metal. Instead, metal is displaced while a groove is formed into the outer surface of the pipe wall. The groove configuration has slightly rounded edges resulting in a less flexible joint than a cut groove joint. This reduces available pipe joint movement by 50% over cut grooved coupling joints. Roll grooving is commonly used on a wide range of pipe thicknesses up to 0.375" wall steel pipe and sizes to 24" O.D.



Roll Grooving



The I.D. "dimple" formed from roll grooving reduces the I.D. (on an average) less than 2%.



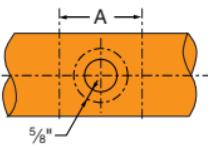
Available Movement  
Roll Groove vs. Cut Groove

## PIPE PREPARATION, CONT'D.

**BRANCH OUTLET PIPE: CLAMP-T®**

Clamp-T installations require the cutting of a hole through the pipe wall. The hole must be properly sized and located on the centerline of the pipe to assure reliable performance of the Clamp-T gaskets.

After the hole has been cut into the pipe wall, any burrs and sharp or rough edges must be removed from the hole. The outside pipe surfaces within  $\frac{5}{8}$ " of the hole must be clean and smooth. Any scale, projections or indentation which might effect the gasket sealing on the pipe must be removed. The surface around the entire circumference of the pipe within the "A" dimension in the charts must be free from dirt, scale, or projections which might effect the proper assembly of the Clamp-T.



CLAMP-T INSTALLATION			
Branch Size	Hole Dimensions		Surface Prep. "A"
	Hole Saw Size	Max. Perm. Diameter	
DN/mm	In./mm	In./mm	In./mm
1/2, 3/4, 1	1 1/2	1 5/8	3 1/2
15, 20, 25	38.1	41.3	88.9
1 1/4, 1 1/2	2	2 1/8	4
32, 40	50.8	54.0	101.6
2	2 1/2	2 5/8	4 1/2
50	63.5	66.7	114.3
2 1/2	2 3/4	2 7/8	4 3/4
65	69.9	73.0	120.7
3	3 1/2	3 5/8	5 1/2
80	88.9	92.1	139.7
4	4 1/2	4 5/8	6 1/2
100	114.3	117.5	165.1

**SOCK-IT®**

For Sock-It Fittings, the pipe ends must be square cut as measured from a true square line.

The maximum allowable tolerance is 0.030" (0.76mm) for all sizes. Any sharp edges, burrs, etc. left on the pipe from cutting must be removed. If these are not removed, they may damage the gasket as the pipe is inserted into the Sock-It Fitting.

After cutting, pipe ends must be completely cleaned a minimum of 1" (25.4mm) back from the pipe end to remove all pipe coating, weld beads, rust, sharp projections, etc., which might effect gasket sealing integrity.

**PIPE TOLERANCES**

Size	Schedule 10 & 40		Min. O.D.	XL Min. O.D.
	Nom. O.D.	Max. O.D.		
DN/mm	In./mm	In./mm	In./mm	In./mm
1	1.315	1.325	1.295	1.285
25	33.4	33.6	32.9	32.6
1 1/4	1.660	1.670	1.642	1.630
32	42.2	42.4	41.7	41.4
1 1/2	1.900	1.910	1.882	1.875
40	48.3	48.5	47.8	47.6
2	2.375	2.385	2.357	2.352
50	60.3	60.6	59.9	59.7
2 1/2	2.875	2.904	2.846	2.837
65	73.0	73.8	72.3	72.1

**NOTE:** When Allied XL pipe is used it is necessary only to remove sharp edges and burrs at the end of the pipe. No additional cleaning is required.

## PIPE PREPARATION, CONT'D.

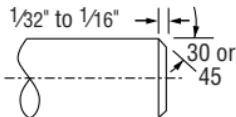
### SOCK-IT®, CONT'D.

#### ACCEPTABLE PIPE END CONFIGURATION

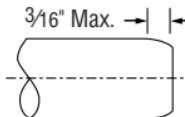
Remove Burr & Sharp Edge



Square cut pipe with O.D. burr & sharp edge removed is preferred configuration.



Beveled pipe. Bevel not to exceed  $\frac{1}{16}$ ".



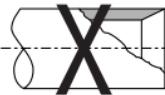
Soft pipe when roll cut may be swaged inward. Swaged portion not to exceed



### ROUGHNECK®

Plain-End pipe for use with Fig. 7005 Roughneck Couplings must be free of any notches, bumps, weld bead, score marks, etc. for at least  $1\frac{1}{2}$ " (38mm) back from the pipe end to provide a smooth sealing surface for the gasket. Pipe ends (plain or beveled end) must be square cut as measured from a true square line with the maximum allowable tolerance as follows: 0.030" (0.7mm) for 2" through 3"; 0.045 (1.1mm) for 4" through 6"; and 0.060" (1.5mm) for 8" sizes. The nominal outside diameter of pipe should not vary more than  $\pm 1\%$  for sizes up to  $2\frac{1}{2}$ ",  $+1\frac{1}{32}$ " for sizes 3"-5";  $+1/16\text{-}1/32$ " for sizes 6" and larger. Pipe ends must be marked a distance of 1" from the pipe end for Sizes 2"-4" and  $1\frac{1}{4}$ " from the pipe end for Sizes 5"-8" as a guide for centering of the gasket on the pipe ends.

#### UNACCEPTABLE



Excessive chamfer on I.D. will tend to cut gasket during assembly.



Abrasive wheels & saws leave edge burrs especially pronounced on one side.



Dull wheel cutter produces a raised ridge at the pipe O.D. giving an oversize diameter.

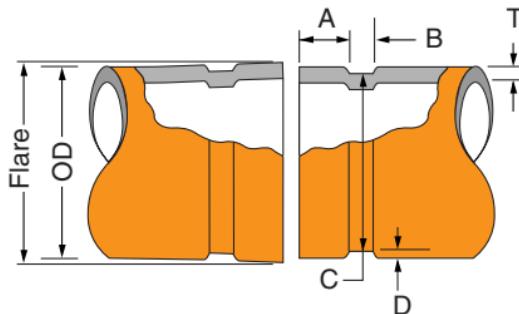
The sharp O.D. edge left by different methods of cutting pipe **must be removed**. If this sharp edge is not removed, it may damage the gasket as the pipe is inserted into the Sock-It Fitting.

GRUVLOK STANDARD ROLL GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE									
-1-	-2-		-3-	-4-	-5-		-6-	-7-	-8-
Nominal Pipe Size	O.D.		"A"	"B"	"C" Actual	"C" Tol. +0.000	"D" (Ref. Only)	"T" Min. Allow. Wall Thick	Max. Flare Dia.
	Actual	Tolerance	±0.030/ ±0.76	±0.030/ ±0.76					
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm
1	1.315	+0.028	-0.015	0.625	0.281	1.190	-0.015	0.063	0.065
25	33.4	+0.71	-0.38	15.88	7.14	30.23	-0.38	1.60	1.7
1½	1.660	+0.029	-0.016	0.625	0.281	1.535	-0.015	0.063	0.065
32	42.2	+0.74	-0.41	15.88	7.14	38.99	-0.38	1.60	1.7
1¾	1.900	+0.019	-0.019	0.625	0.281	1.775	-0.015	0.063	0.065
40	48.3	+0.48	-0.48	15.88	7.14	45.09	-0.38	1.60	1.7
2	2.375	+0.024	-0.024	0.625	0.344	2.250	-0.015	0.063	0.065
50	60.3	+0.61	-0.61	15.88	8.74	57.15	-0.38	1.60	1.7
2½	2.875	+0.029	-0.029	0.625	0.344	2.720	-0.018	0.078	0.083
65	73.0	+0.74	-0.74	15.88	8.74	69.09	-0.46	1.98	2.1
3 O.D.	2.996	+0.030	-0.030	0.625	0.344	2.845	-0.018	0.076	0.083
76.1	76.1	+0.76	-0.76	15.88	8.74	72.26	-0.46	1.93	2.1
3	3.500	+0.035	-0.031	0.625	0.344	3.344	-0.018	0.078	0.083
80	88.9	+0.89	-0.79	15.88	8.74	84.94	-0.46	1.98	2.1
3½	4.000	+0.040	-0.031	0.625	0.344	3.834	-0.020	0.083	0.083
90	101.6	+1.02	-0.79	15.88	8.74	97.38	-0.51	2.11	2.1
4¼ O.D.	4.250	+0.042	-0.031	0.625	0.344	4.084	-0.020	0.083	0.083
108.0	108.0	+1.07	-0.79	15.88	8.74	103.73	-0.51	2.11	2.1
4	4.500	+0.045	-0.031	0.625	0.344	4.334	-0.020	0.083	0.083
100	114.3	+1.14	-0.79	15.88	8.74	110.08	-0.51	2.11	2.1
5¼ O.D.	5.236	+0.052	-0.031	0.625	0.344	5.084	-0.020	0.076	0.109
133.0	133.0	+1.32	-0.79	15.88	8.74	129.13	-0.51	1.93	2.8
									5.350
									135.9

## PIPE PREPARATION, CONT'D.

GRUVLOK STANDARD ROLL GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE										
-1-	-2-		-3-	-4-	-5-		-6-	-7-	-8-	
Nominal Pipe Size	O.D.			"A"	"B"	"C"	"C" Tol. +0.000	"D"	"T"	Max. Flare Dia.
	Actual	Tolerance		±0.030/ ±0.76	±0.030/ ±0.76	Actual	+0.000	(Ref. Only)	Min. Allow. Wall Thick	
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm	In./mm
5½ O.D. 139.7	5.500 139.7	+0.055 +1.40	-0.031 -0.79	0.625 15.88	0.344 8.74	5.334 135.48	-0.020 -0.51	0.083 2.11	0.109 2.8	5.600 142.2
5 125	5.563 141.3	+0.056 +1.42	-0.031 -0.79	0.625 15.88	0.344 8.74	5.395 137.03	-0.022 -0.56	0.084 2.13	0.109 2.8	5.660 143.8
6¼ O.D. 159.0	6.259 159.0	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.344 8.74	6.084 154.53	-0.022 -0.56	0.088 2.24	0.109 2.8	6.350 161.3
6½ O.D. 165.1	6.500 165.1	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.344 8.74	6.334 160.88	-0.022 -0.56	0.085 2.16	0.109 2.8	6.600 167.6
6 150	6.625 168.3	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.344 8.74	6.455 163.96	-0.022 -0.56	0.085 2.16	0.109 2.8	6.730 170.9
8 200	8.625 219.1	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.469 11.91	8.441 214.40	-0.025 -0.64	0.092 2.34	0.109 2.8	8.800 223.5
10 250	10.750 273.1	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.469 11.91	10.562 268.27	-0.027 -0.69	0.094 2.39	0.134 3.4	10.920 277.4
12 300	12.750 323.9	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.469 11.91	12.531 318.29	-0.030 -0.76	0.109 2.77	0.156 4.0	12.920 328.2
14 O.D. 355.6	14.000 355.6	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.469 11.91	13.781 350.04	-0.030 -0.76	0.109 2.77	0.156 4.0	14.100 358.1
16 O.D. 406.4	16.000 406.4	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.469 11.91	15.781 400.84	-0.030 -0.76	0.109 2.77	0.165 4.2	16.100 408.9

GRUVLOK STANDARD ROLL GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE										
-1-	-2-		-3-	-4-	-5-		-6-	-7-	-8-	
Nominal Pipe Size	O.D.			"A"	"B"	"C" Actual	"C" Tol. +0.000	"D" (Ref. Only)	"T" Min. Allow. Wall Thick	Max. Flare Dia.
	Actual	Tolerance		±0.030/ ±0.76	±0.030/ ±0.76					
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm	In./mm
18 O.D.	18.000	+0.063	-0.031	1.000	0.469	17.781	-0.030	0.109	0.165	18.160
457.2	457.2	+1.60	-0.79	25.40	11.91	451.64	-0.76	2.77	4.2	461.3
20 O.D.	20.000	+0.063	-0.031	1.000	0.469	19.781	-0.030	0.109	0.188	20.160
508.0	508.0	+1.60	-0.79	25.40	11.91	502.44	-0.76	2.77	4.8	512.1
24 O.D.	24.000	+0.063	-0.031	1.000	0.500	23.656	-0.030	0.172	0.218	24.200
609.6	609.6	+1.60	-0.79	25.40	12.70	600.86	-0.76	4.37	5.5	614.7
30 O.D.	30.000	+0.093	-0.031	1.750▼	0.625	29.500	-0.063	0.250	0.250	30.200
762.0	762.0	2.36	0.79	44.45	15.88	749.30	1.60	6.35	6.35	761.1



**NOTE:** VdS - Roll Grooving Approval Specifications, see the Technical Data/Install Instructions section on Anvil's web site  
- [www.anvilintl.com](http://www.anvilintl.com)

**PIPE PREPARATION, CONT'D.****ROLL GROOVE SPECIFICATIONS, NOTES**

**COLUMN 1** - Nominal IPS Pipe size.Nominal ISO Pipe size.

**COLUMN 2** - IPS outside diameter.ISO outside diameter.

**COLUMN 3** - Gasket seat must be free from scores, seams, chips, rust or scale which may interfere with proper sealing of the gasket. Gasket seat width (Dimension A) is to be measured from the pipe end to the vertical flank in the groove wall.

**COLUMN 4** - Groove width (Dimension B) is to be measured between vertical flank of the groove size walls.

**COLUMN 5** - The groove must be of uniform depth around the entire pipe circumference. (See column 6).

**COLUMN 6** - Groove depth: for reference only. Groove must conform to the groove diameter "C" listed in column 5.

**COLUMN 7** - Minimum allowable wall thickness which may be roll grooved.

**COLUMN 8** - Maximum allowable pipe end flare diameter. Measured at the most extreme pipe end diameter of the gasket seat area.

**Out of roundness:** Difference between maximum O.D. and minimum O.D. measured at 90° must not exceed total O.D. tolerance listed (reference column 2).

**For IPS pipe,** the maximum allowable tolerance from square cut ends is 0.03" for 1" thru 3½"; 0.045" for 4" thru 6"; and 0.060" for sizes 8" and above measured from a true square line.

**For ISO size pipe,** the maximum allowable tolerance from square cut ends is 0.75mm for sizes 25mm-80mm; 1.15mm for sizes 100mm-150mm; and 1.50mm for sizes 200mm and above, measured from a true square line.

**Beveled-End Pipe** in conformance with ANSI B16.25 (37½°) is acceptable, however square cut is preferred. Seams must be ground flush with the pipe O.D. and ID prior to roll grooving. Failure to do so may result in damage to the roll grooving machine and unacceptable roll grooves may be produced.

**Weld seams** must be ground flush with the pipe O.D. and ID prior to roll grooving. Failure to do so may result in damage to the roll grooving machine and unacceptable roll grooves may be produced.

▼ "A" tolerance +0.030" / -0.060" (+0.77 / -1.54 mm)

## PIPE PREPARATION, CONT'D.

GRUVLOK STANDARD CUT GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE									
-1-	-2-			-3-	-4-	-5-		-6-	-7-
Nominal IPS Pipe Size	O.D.			Gasket Seat "A" $\pm 0.030$ $\pm 0.76$	Groove Width "B" $\pm 0.030$ $\pm 0.76$	Groove Diameter "C"		Actual Groove Depth "D" (Ref. Only)	Min. Allow. Wall Thick. "T"
	Actual	Tolerance				Actual	Tol. $+0.000$		
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm
1	1.315	+0.028	-0.015	0.625	0.312	1.190	-0.015	0.062	0.133
25	33.4	+0.71	-0.38	15.88	7.92	30.23	-0.38	1.6	3.4
1½	1.660	+0.029	-0.016	0.625	0.312	1.535	-0.015	0.062	0.140
32	42.2	+0.74	-0.41	15.88	7.92	38.99	-0.38	1.6	3.6
1½	1.900	+0.019	-0.019	0.625	0.312	1.775	-0.015	0.062	0.145
40	48.3	+0.48	-0.48	15.88	7.92	45.09	-0.38	1.6	3.7
2	2.375	+0.024	-0.024	0.625	0.312	2.250	-0.015	0.062	0.154
50	60.3	+0.61	-0.61	15.88	7.92	57.15	-0.38	1.6	3.9
2½	2.875	+0.029	-0.029	0.625	0.312	2.720	-0.018	0.078	0.187
65	73.0	+0.74	-0.74	15.88	7.92	69.09	-0.46	2.0	4.8
3 O.D.	2.996	+0.030	-0.030	0.625	0.312	2.845	-0.018	0.076	0.188
76.1	76.1	+0.76	-0.76	15.88	7.92	72.26	-0.46	1.9	4.8
3	3.500	+0.035	-0.031	0.625	0.312	3.344	-0.018	0.078	0.188
80	88.9	+0.89	-0.79	15.88	7.92	84.94	-0.46	2.0	4.8
3½	4.000	+0.040	-0.031	0.625	0.312	3.834	-0.020	0.083	0.188
90	101.6	+1.02	-0.79	15.88	7.92	97.38	-0.51	2.1	4.8
4¼ O.D.	4.250	+0.042	-0.031	0.625	0.375	4.084	-0.020	0.083	0.203
108.0	108.0	+1.07	-0.79	15.88	9.53	103.73	-0.51	2.1	5.2
4	4.500	+0.045	-0.031	0.625	0.375	4.334	-0.020	0.083	0.203
100	114.3	+1.14	-0.79	15.88	9.53	110.08	-0.51	2.1	5.2

## PIPE PREPARATION, CONT'D.

GRUVLOK STANDARD CUT GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE									
-1-	-2-		-3-	-4-	-5-		-6-	-7-	
Nominal IPS Pipe Size	O.D.		Gasket Seat "A" $\pm 0.030$ $\pm 0.76$	Groove Width "B" $\pm 0.030$ $\pm 0.76$	Groove Diameter "C"		Actual Groove Depth "D" (Ref. Only)	Min. Allow. Wall Thick. "T"	
	Actual	Tolerance			Actual	Tol. $+0.000$			
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm
5 $\frac{1}{4}$ O.D. 133.0	5.236 133.0	+0.052 +1.32	-0.031 -0.79	0.625 15.88	0.375 9.53	5.084 129.13	-0.020 -0.51	0.076 1.9	0.203 5.2
5 $\frac{1}{2}$ O.D. 139.7	5.500 139.7	+0.055 +1.40	-0.031 -0.79	0.625 15.88	0.375 9.53	5.334 135.48	-0.020 -0.51	0.083 2.1	0.203 5.2
5 125	5.563 141.3	+0.056 +1.42	-0.031 -0.79	0.625 15.88	0.375 9.53	5.395 137.03	-0.022 -0.56	0.084 2.1	0.203 5.2
6 $\frac{1}{4}$ O.D. 159.0	6.259 159.0	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.084 154.53	-0.022 -0.56	0.088 2.2	0.249 6.3
6 $\frac{1}{2}$ O.D. 165.1	6.500 165.1	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.334 160.88	-0.022 -0.56	0.085 2.2	0.219 5.6
6 150	6.625 168.3	+0.063 +1.60	-0.031 -0.79	0.625 15.88	0.375 9.53	6.455 163.96	-0.022 -0.56	0.085 2.2	0.219 5.6
8 200	8.625 219.1	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.437 11.10	8.441 214.40	-0.025 -0.64	0.092 2.3	0.238 6.1
10 250	10.750 273.1	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	10.562 268.27	-0.027 -0.69	0.094 2.4	0.250 6.4
12 300	12.750 323.9	+0.063 +1.60	-0.031 -0.79	0.750 19.05	0.500 12.70	12.531 318.29	-0.030 -0.76	0.109 2.8	0.279 7.1
14 O.D. 355.6	14.000 355.6	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.500 12.70	13.781 350.04	-0.030 -0.76	0.109 2.8	0.281 7.1

## PIPE PREPARATION, CONT'D.

GRUVLOK STANDARD CUT GROOVE SPECIFICATION FOR STEEL & OTHER IPS OR ISO SIZE PIPE									
-1-	-2-			-3-	-4-	-5-		-6-	-7-
Nominal IPS Pipe Size	O.D.			Gasket Seat "A" $\pm 0.030$ $\pm 0.76$	Groove Width "B" $\pm 0.030$ $\pm 0.76$	Groove Diameter "C"		Actual Groove Depth "D" (Ref. Only)	Min. Allow. Wall Thick. "T"
	Actual	Tolerance				Actual	Tol. $+0.000$		
In./DN(mm)	In./mm	+In./mm	-In./mm	In./mm	In./mm	In./mm	-In./mm	In./mm	In./mm
16 O.D. 406.4	16.000 406.4	+0.063 +1.60	-0.031 -0.79	0.938 23.83	0.500 12.70	15.781 400.84	-0.030 -0.76	0.109 2.8	0.312 7.9
18 O.D. 457.2	18.000 457.2	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.500 12.70	17.781 451.64	-0.030 -0.76	0.109 2.8	0.312 7.9
20 O.D. 508.0	20.000 508.0	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.500 12.70	19.781 502.44	-0.030 -0.76	0.109 2.8	0.312 7.9
24 O.D. 609.6	24.000 609.6	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.563 14.30	23.656 600.86	-0.030 -0.76	0.172 4.4	0.375 9.5
28 I.D. 733.4	28.875 733.4	+0.063 +1.60	-0.031 -0.79	1.000 25.40	0.563 14.30	28.531 724.69	-0.030 -0.76	0.172 4.4	0.437 11.1
30 ID 787.4	31.000 787.4	+0.063 +1.60	-0.031 -0.79	1.250 31.75	0.625 15.88	30.594 777.09	-0.030 -0.76	0.203 5.2	0.500 12.7
30 O.D. 762.0	30.000 762.0	0.093 2.36	0.031 0.79	1.750▼ 44.45	0.625 15.88	29.500 749.30	0.063 1.60	0.250 6.35	0.625 15.88

**PIPE PREPARATION, CONT'D.****CUT GROOVE SPECIFICATIONS, NOTES****COLUMN 1 -**

Nominal IPS Pipe size.

Nominal ISO Pipe size.

**COLUMN 2 -**

IPS outside diameter.

ISO outside diameter.

**COLUMN 3 & 4 -**

Gasket seat must be free from scores, seams, chips, rust or scale which may interfere with proper coupling assembly.

**COLUMN 5 -**

The groove must be of uniform depth around the entire pipe circumference. (See column 6).

**COLUMN 6 -**

Groove depth: for reference only. Groove must conform to the groove diameter "C" listed in column 5.

**COLUMN 7 -**

Minimum allowable wall thickness which may be cut grooved.

**Out of roundness:** Difference between maximum O.D. and minimum O.D. measured at 90° must not exceed total O.D. tolerance listed.

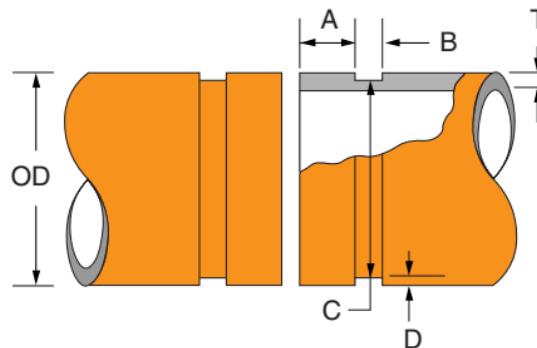
**For IPS pipe,** the maximum allowable tolerance from square cut ends is 0.03" for 1" thru 3½"; 0.045" for 4" thru 6"; and 0.060" for sizes 8" and above measured from a true square line.

**For ISO size pipe,** the maximum allowable tolerance from square cut ends is 0.75mm for sizes 25mm-80mm; 1.15mm for sizes 100mm-150mm; and 1.50mm for sizes 200mm and above, measured from a true square line.

**Beveled-End Pipe** in conformance with ANSI B16.25 (37½°) is acceptable, however square cut is preferred.

**Not to be used with End Guard gaskets.**

▼ "A" tolerance +0.030" / -0.060" (+0.77 / -1.54 mm)



When designing the hangers, supports and anchors for a grooved-end pipe system, the piping designer must consider certain unique characteristics of the grooved type coupling in addition to many universal pipe hanger and support design factors. As with any pipe system, the hanger or support system must provide for

- 1) the weight of the pipe, couplings, fluid & pipe system components;
- 2) reduce stresses at pipe joints; and
- 3) permit required pipe system movement to relieve stress.

The following factors should be considered when designing hangers and supports for a grooved-end pipe system.

#### PIPE HANGER SPACING:

The following charts show the maximum span between pipe hangers for straight runs of standard weight steel pipe filled with water or other similar fluids.

Do not use these values where critical span calculations are made or where there are concentrated loads between supports.

For straight runs without concentrated loads and where full linear movement is *NOT* required use the table on right.

HANGER SPACING LINEAR MOVEMENT NOT REQ'D	
Nominal Pipe Size Range	Maximum Span Between Supports
In./DNmm	Feet/meters
1	7
25	2.6
1½-2	10
32-50	3.0
2½-4	12
65-100	3.7
5-8	14
125-200	4.3
10-12	16
250-300	4.9
14-16	18
350-400	5.5
18-24	20
450-600	6.1

For straight runs without concentrated loads and where full linear movement *IS* required use the table below.

#### HANGER SPACING - FLEXIBLE SYSTEM, STEEL PIPE FULL LINEAR MOVEMENT IS REQ'D AVERAGE HANGERS PER PIPE LENGTH EVENLY SPACED

Nominal Pipe Size Range	Pipe Length in Feet/Meters									
	In.	7	10	12	15	20	22	25	30	35
DNmm	2.1	3.3	3.7	4.6	6.1	6.7	7.6	9.1	10.7	12.2
1-2	1	2	2	2	3	3	4	4	5	6
25-50										
2½-4	1	1	2	2	2	2	2	3	4	4
65-100										
5-8	1	1	1	2	2	2	2	3	3	3
125-200										

## PIPE SUPPORT, CONT'D.

HANGER SPACING - RIGID SYSTEMS SUGGESTED MAXIMUM SPAN BETWEEN SUPPORTS								
Nominal Size <i>In./DNmm</i>	STEEL PIPE						COPPER TUBE	
	Suggested Maximum Span Between Supports-Feet/Meters						Water Service	Gas & Air Service
	Water Service		Air Service					
1	*	**	***	*	**	***	Water Service	Gas & Air Service
25	7	9	12	9	10	12		
2.1	2.1	2.7	3.7	2.7	3.0	3.7	Water Service	Gas & Air Service
32	2.1	3.4	3.7	2.7	3.6	3.7		
1½	7	11	12	9	12	12	Water Service	Gas & Air Service
32	2.1	3.4	3.7	2.7	3.6	3.7		
1½	7	12	15	9	13	15	Water Service	Gas & Air Service
40	2.1	3.7	4.6	2.7	4	4.6		
2	10	13	15	13	15	15	Water Service	Gas & Air Service
50	3	4	4.6	4	4.6	4.6		
2½	11	15	15	14	17	15	Water Service	Gas & Air Service
65	3.4	4.6	4.6	4.3	5.1	4.6		
3 OD	11	15	15	14	17	15	Water Service	Gas & Air Service
65	3.4	4.6	4.6	4.3	5.1	4.6		
3	12	16	15	15	19	15	Water Service	Gas & Air Service
80	3.7	4.8	4.6	4.6	5.7	4.6		
3½	13	18	15	15	21	15	Water Service	Gas & Air Service
90	4	5.4	4.6	4.6	6.3	4.6		
4	14	18	15	17	21	15	Water Service	Gas & Air Service
100	4.3	5.4	4.6	5.2	6.4	4.6		
4¼	14	18	15	17	19	15	Water Service	Gas & Air Service
100	4.3	5.4	4.6	5.2	5.7	4.6		
5	16	20	15	20	24	15	Water Service	Gas & Air Service
125	4.9	6.0	4.6	6.1	7.3	4.6		
5½	15	18	15	19	22	15	Water Service	Gas & Air Service
125	4.6	5.5	4.6	5.2	6.6	4.6		
5½	16	19	15	20	24	15	Water Service	Gas & Air Service
125	4.9	5.8	4.6	6.1	7.3	4.6		

\* Spacing by ANSI-B31.1 Power Piping Code.

\*\* Spacing by ANSI-B31.9 Building Service Piping Code, (1996 Edition), Fig. 921.1.3c, Table a, 250 psi and Fig. 921.1.3D, table a

\*\*\* Spacing by NFPA-13 Installation of Sprinkler Systems, (1999 Edition), Table 6-2.2.

## PIPE SUPPORT, CONT'D.

Nominal Size <i>In./DNmm</i>	HANGER SPACING - RIGID SYSTEMS SUGGESTED MAXIMUM SPAN BETWEEN SUPPORTS						COPPER TUBE	
	STEEL PIPE						Water Service **	Gas & Air Service **
	Suggested Maximum Span Between Supports-Feet/Meters			Air Service				
*	**	***	*	**	***	*	**	**
6	17	21	15	21	26	15	14	21
150	5.2	6.3	4.6	6.4	7.8	4.6	4.2	6.3
6½	16	20	15	20	24	15	-	-
150	4.9	6.0	4.6	6.1	7.3	4.6	-	-
6½ OD	17	21	15	21	25	15	-	-
150	5.2	6.3	4.6	6.4	7.6	4.6	-	-
8	19	23	15	24	29	15	-	-
200	5.8	6.9	4.6	7.3	8.7	4.6	-	-
10	19	25	15	24	33	15	-	-
250	5.8	7.5	4.6	7.3	9.9	4.6	-	-
12	23	26	15	30	36	15	-	-
300	7	7.8	4.6	9.1	10.8	4.6	-	-
14	23	26	15	30	37	15	-	-
350	7	7.8	4.6	9.1	11.1	4.6	-	-
16	27	26	15	35	40	15	-	-
400	8.2	7.8	4.6	10.7	12.0	4.6	-	-
18	27	27	15	35	42	15	-	-
450	8.2	8.1	4.6	10.7	12.6	4.6	-	-
20	30	27	15	39	45	15	-	-
500	9.1	8.1	4.6	11.9	13.5	4.6	-	-
24	32	26	15	42	48	15	-	-
600	9.8	7.8	4.6	12.8	14.7	4.6	-	-

\* Spacing by ANSI-B31.1 Power Piping Code.

\*\* Spacing by ANSI-B31.9 Building Service Piping Code, (1996 Edition), Fig. 921.1.3c, Table a, 250 psi and Fig. 921.1.3D, table a

\*\*\* Spacing by NFPA-13 Installation of Sprinkler Systems, (1999 Edition), Table 6-2.2.

## PIPE SUPPORT, CONT'D.

### Considerations for the Hanging or Supporting of Grooved Piping Systems

Grooved piping products have a very good maintenance track record out in the field. Whenever there is a "perceived" problem with installed grooved product, a high percentage are often related to the hanging or supporting method or application chosen. Although supported very similarly to welded piping systems, a few considerations should be given to assure the proper selection and application of hangers and supports used on a grooved piping system such as Anvil's Gruvlok® brand.

#### REVIEW REQUIREMENTS AND LOGISTICS

A variety of hangers and supports are typically used on grooved piping systems, ranging from a simple band hanger, clevis hanger, and trapeze supports to more intricate rack designs using structural steel or a mechanical framing/strut system. All of these are acceptable hanging or supporting methods but they are dependent on the project's type, design and specification requirements. With this in mind, a vital first step is to refer to the project and code requirements when choosing the proper hanging or supporting method.

Project logistics is another consideration regardless of system type. Quite often hangers and supports are an after thought on a project simply because the big-ticket items, such as labor, major equipment and schedule, are the focus of the project team. However, hangers and supports are one of the first components needed on a project since you cannot hang pipe without them.

In nearly every hanger or support assembly there are three components that make up the assembly. These components are an upper attachment (beam or structural attachment), intermediate attachment (rod, couplings, eye nuts, etc.) and the lower attachment (pipe clamps, U-bolts, trapezes). See accompanying illustrations for examples of typical assemblies. All three components should arrive on the project site together and early. To save costly field labor hours, consideration might be given to having the hangers or supports pre-assembled by the manufacturer or fabricated in the contractor's shop. Components can also be bundled and tagged by system or area of the project so they can be easily assembled and located on-site.

#### MAKE A MATCH

The type of grooved coupling used on a project is the next consideration to choosing the correct hanger or support method. The proper maximum spacing allowables governed by project specifications, the applicable code and/or the hanger manufacturer's recommendations all must also be reviewed. Flexible couplings used on horizontal runs of pipe need to be supported at every coupling and usually require intermediate supports to satisfy the maximum spacing allowable requirements. Rigid couplings, on the other hand, can be hung or supported based on the maximum spacing requirements only. In addition, whenever there is a change in direction of the piping system a hanger or support is usually required immediately following that change in direction and then the system is hung or supported accordingly.

## Considerations for the Hanging or Supporting of Grooved Piping Systems

### PRESSURE POINT

System pressurization should also be reviewed when choosing the proper hanging or support method. As the couplings are installed, the pipe ends can either be butted up tight to one another or a gap can exist. Once the system is pressurized, those areas or joints where the pipe ends are butted up tight and held by a grooved coupling can "pop" or grow to the maximum gap depending on the coupling chosen. The joint at a flexible grooved coupling can expand about  $\frac{1}{4}$ " at each coupling whereas the joint at a rigid grooved coupling can grow about  $\frac{3}{32}$ ". If there is a long run of horizontal or vertical pipe with multiple joints the overall length of the system will grow depending upon which grooved coupling you have chosen.

For example, if you have a grooved piping system that is 400 ft. long there will be roughly 19 grooved joints (assuming 21 ft. lengths of pipe are used). If you multiply the number of joints by the growth of each joint you can determine the overall growth of the system due to pressurization. If it is a flexible system,  $19 \text{ joints} \times .25" = 4.75"$  of overall growth. A rigid system would be  $19 \text{ joints} \times .0938" = 1.78"$  of overall growth.

As one can see, this growth due to pressurization can have a significant impact on the hangers or supports used on a project. One way to avoid this growth is to install the grooved joints at full gap so that pressurization has no impact at testing or start up. If this is not possible, then periodic air pressurization as the system is installed will expand the grooved joints to full gap and the hangers or supports can be adjusted accordingly.

### HOT AND COLD

Thermal expansion is another important consideration when choosing hangers or supports for a grooved system. This is especially important on hot systems versus chilled systems since the amount of thermal expansion will be greater on hot systems as opposed to the thermal contraction that will occur on chilled systems. This is all due to the temperature variation from ambient conditions when the pipe is installed to operating conditions.

For example, if you again take 400 ft. of grooved piping, let us assume the system is heating hot water that will operate at 170°F. The pipe is installed under ambient conditions assumed to be at 70°F so you have a 100°F variation in temperature. At 70°F the pipe has a coefficient of thermal expansion of 0.0 in/ft but at 170°F the pipe has a coefficient of thermal expansion of 0.0076 in/ft. To determine the total thermal expansion of the pipe from ambient temperature to operating temperature you multiply the length of pipe by the coefficient of thermal expansion. In this case  $400 \text{ ft.} \times 0.0076 \text{ in/ft.} = 3.04 \text{ in.}$  In other words the pipe has grown in length over 3 inches because of the thermal expansion.

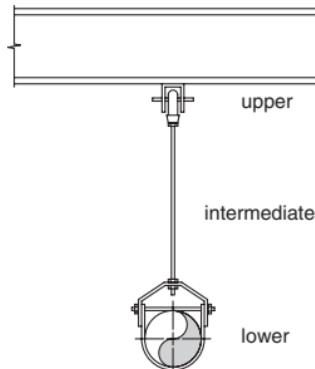
This is significant growth especially if there is a change of direction at the end of the 400 ft. pipe run or there are branch lines coming off the main run. If this thermal growth exceeds the allowable deflection of a grooved joint, especially where a change of direction or a branch line connects, then problems could occur. Thermal growth cannot be stopped. It can only be controlled by the use of anchors and expansion joints or expansion loops.

## PIPE SUPPORT, CONT'D.

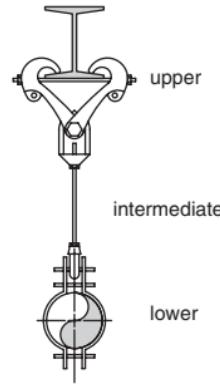
### Considerations for the Hanging or Supporting of Grooved Piping Systems

It is also important to hang or support the pipe with rolls or slides and use guides to control the thermal expansion of the pipe into an expansion joint or expansion loop. The use of static hangers, such as clevis hangers, should not be considered on pipe that is thermally expanding. When using trapeze hangers for multiple systems it is important to have "like" systems on the trapeze, that is, systems that are operating near the same temperature. If you combine hot systems with cold systems on a trapeze, the thermal expansion of the hot system can cause the trapeze to possibly twist and fail or excessive stress could be induced on the grooved joints on all of the systems on the trapeze. Hot systems should be hung or supported independently of cold or ambient systems or a means should be provided, such as pipe rolls or pipe slides, to allow the hot systems to thermally expand on the trapeze.

If the pipe is a vertical riser then consideration must be given to the use of spring hangers to allow the pipe to grow vertically up or down depending upon how the pipe is anchored while still supporting the pipe. Vertical pipe thermally expands the same amount as horizontal pipe and this has to be taken into consideration relating to supports, expansion joints or expansion loops. If the vertical pipe is supported by friction/riser clamps only and the pipe expands vertically upward, the clamps will grow with the pipe off the penetration or supporting structure and no longer provide support. If the growth is downward, the friction clamps resting on the penetration or supporting structure can either fail or the pipe may overcome the friction force and push it's way through the clamp as the pipe thermally expands downward. In either



**Clevis Hanger Assembly**



**Double Bolt Pipe Clamp Assembly**

case the clamps are no longer supporting the pipe as intended and this may induce excessive stress on the grooved joints.

Whether it is horizontal or vertical grooved pipe, growth of the piping system due to pressurization and thermal expansion must be considered. On hot systems, both must be taken into account and added together to determine the overall growth of the system and the effect on the hangers or supports that are used. In the previous examples, pressurization expansion on the 400 ft. run of pipe was 4.75" for a flexible joint system and 1.78" for a rigid joint system and the thermal expansion was 3.04". Adding these combinations together would result in

## PIPE SUPPORT, CONT'D.

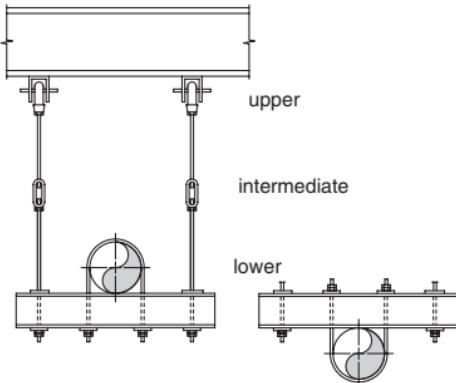
### Considerations for the Hanging or Supporting of Grooved Piping Systems

a total pipe growth of 7.79" for a flexible system or 4.82" for a rigid system, regardless of the horizontal or vertical orientation of the pipe. Again, this is a significant amount of growth relating to hangers and supports and the resulting stresses induced on grooved joints.

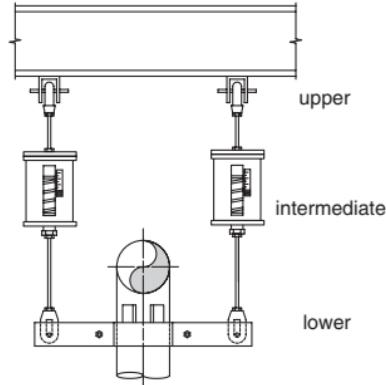
#### CONSIDER SOME RESTRAINT

Although grooved systems in seismic zones perform extremely well, consideration should be given to how a grooved system is seismically restrained. If you have growth due to pressurization and/or thermal expansion consideration should be given on how to restrain the system

while still allowing growth to occur. Seismic restraints in the longitudinal direction of a long pipe run may restrict the growth of the pipe inducing stresses into the grooved couplings. Seismic restraints in the lateral direction should have little impact on expansion except where the system has a change in direction. If the seismic restraints are placed laterally after a change in direction at the end of a long run of pipe, the expansion of the long pipe run may be restricted and this could induce excessive stress into the grooved joints.



Trapeze Assembly



Spring Riser Hanger Assembly

By reviewing the couplings to be used on a project, pressurization, thermal expansion and seismic restraints, one can best determine the proper selection and application of hangers and supports for a grooved piping system. This will, in turn, help ensure that grooved piping systems will continue to enjoy a solid reputation in the areas of maintenance and downtime.

## A TYPICAL PIPE HANGER SPECIFICATION

### 1. SCOPE

This specification shall apply for the design and fabrication of all hangers, supports, anchors, and guides. Where piping design is such that exceptions to this specification are necessary, the particular system will be identified, and the exceptions clearly listed through an addendum which will be made a part of the specification.

### 2. DESIGN

- (a) All supports and parts shall conform to the latest requirements of the ASME Code for Pressure Piping B31.1 and MSS Standard Practice SP-58, SP-69, SP-89 and SP-90 except as supplemented or modified by the requirements of this specification.
- (b) Designs generally accepted as exemplifying good engineering practice, using stock or production parts, shall be utilized wherever possible.
- (c) Accurate weight balance calculations shall be made to determine the required supporting force at each hanger location and the pipe weight load at each equipment connection.
- (d) Pipe hangers shall be capable of supporting the pipe in all conditions of operation. They shall allow free expansion and contraction of the piping, and prevent excessive stress resulting from transferred weight being introduced into the pipe or connected equipment.

(e) Wherever possible, pipe attachments for horizontal piping shall be pipe clamps.

(f) For critical high-temperature piping, at hanger locations where the vertical movement of the piping is  $\frac{1}{2}$ " or more, or where it is necessary to avoid the transfer of load to adjacent hangers or connected equipment, pipe hangers shall be an approved constant support design, as Anvil Fig. 80-V and Fig. 81-H Constant Support Hangers, or equal.

Where transfer of load to adjacent hangers or equipment is not critical, and where the vertical movement of the piping is less than  $\frac{1}{2}$ ", Variable Spring Hangers may be used, provided the variation in supporting effect does not exceed 25% of the calculated piping load through its total vertical travel.

(g) The total travel for Constant Support Hangers will be equal to actual travel plus 20%. In no case will the difference between actual and total travel be less than 1". The Constant Support Hanger will have travel scales on both sides of the support frame to accommodate inspections.

(h) Constant Support Hanger should be individually calibrated before shipment to support the exact load specified. The calibration record of constant support shall be maintained for a period of 20 years to assist the customer in any redesign of the piping system. Witness marks shall be stamped on the Load Adjustment Scale to establish factory calibration reference point.

## A TYPICAL PIPE HANGER SPECIFICATION, CONT'D.

- (i) In addition to the requirements of ASTM-125 all alloy springs shall be shot peened and examined by magnetic particle. The spring rate tolerance shall be  $\pm 5\%$ . All three critical parameters (free height, spring rate and loaded height) of spring coils must be tested for. Each spring coiled must be purchased with a C.M.T.R. and be of domestic manufacture.
- (j) Constant Supports should have a wide range of load adjustability. No less than 10% of this adjustability should be provided either side of the calibrated load for plus or minus field adjustment. Load adjustment scale shall be provided to aid the field in accurate adjustment of loads. Additionally, the constant support should be designed so that load adjustments can be made with-out use of special tools and not have an impact on the travel capabilities of the supports.
- (k) Constant Supports shall be furnished with travel stops which shall prevent upward and downward movement of the hanger. The travel stops will be factory installed so that the hanger level is at the "cold" position. The travel stops will be of such design as to permit future re-engagement, even in the event the lever is at a position other than "cold", without having to make hanger adjustments.
- (l) For non-critical, low temperature systems, where vertical movements up to 2" are anticipated, an approved pre-compressed Variable Spring design similar to Anvil Fig. B-268 may be used. Where movements are of a small magnitude, spring hangers similar to Anvil Fig. 82 may be used.
- (m) Each Variable Spring shall be individually calibrated at the factory and furnished with travel stops. Spring coils must be square to within 1° to insure proper alignment. Each spring coil must be purchased with a C.M.T.R. and be of domestic manufacture.
- (n) All rigid rod hangers shall provide a means of vertical adjustment after erection.
- (o) Where the piping system is subject to shock loads, such as seismic disturbances or thrusts imposed by the actuation of safety valves, hanger design shall include provisions for rigid restraints or shock absorbing devices of approved design, such as Anvil Fig. 200 shock and sway suppressor, or equal.
- (p) Selection of vibration control devices shall not be part of the standard hanger contract. If vibration is encountered after the piping system is in operation, appropriate vibration control equipment shall be installed.
- (q) Hanger rods shall be subject to tensile loading only (see Table III). At hanger locations where lateral or axial movement is anticipated, suitable linkage shall be provided to permit swing.
- (r) Where horizontal piping movements are greater than  $1\frac{1}{2}$ " and where the hanger rod angularly from the vertical is less than or equal to 4 degrees from the cold to hot position of the pipe, the hanger pipe and structural attachments shall be offset in such manner that the rod is vertical in the hot position. When the hanger rod angularity

## A TYPICAL PIPE HANGER SPECIFICATION, CONT'D.

- is greater than 4 degrees from vertical, then structural attachment will be offset so that at no point with the rod angularity exceed 4 degrees from vertical.
- (t) Hangers shall be spaced in accordance with Table 1 and Table 2 on the following page.
- (u) Where practical, riser piping shall be supported independently of the connected horizontal piping.  
Pipe support attachments to the riser piping shall be riser clamp lugs. Welded attachments shall be of material comparable to that of the pipe, and designed in accordance with governing codes.
- (v) Supports, guides, and anchors shall be so designed that excessive heat will not be transmitted to the building steel. The temperature of supporting parts shall be based on a temperature gradient of 100°F per inch distance from the outside surface of the pipe.
- (w) Hanger components shall not be used for purposes other than for which they were designed. They shall not be used for rigging and erection purposes.
- (x) Hydraulic Snubbers - The hydraulic units shall have a temperature stable control valve. The valve shall provide a locking and bleed rate velocity that provides for tamper proof settings. The fluid level indicator for exact reading of reservoir fluid level in any snubber orientation.
- The valve device shall offer a minimum amount of resistance to thermal movement. Any shock force shall cause the suppressor valve to close. With the suppressor valve closed the fluid flow shall essentially stop, thereby causing the unit to resist and absorb the disturbing forces. After the disturbing forces subside, the suppressor valve shall open again to allow free thermal movement of the piping. The suppressor shall have a means of regulating the amount of movement under shock conditions up to the design load for faulted conditions without release of fluid. The suppressor design shall include a fluid bleed system to assure continued free thermal movement after the shock force subsides. The suppressor shall have a hard surfaced, corrosion resistant piston rod supported by a rod bushings and shall be designed so that it is capable of exerting the required force in tension and compression, utilizing the distance.
- (y) Paint - Variable Spring and Constant Support units will be furnished painted with Stewart Bros. Green Semi-Gloss Primer (#10947). All other material will receive one shop coat of a red chromate primer meeting the requirements of Federal Specification TT-P-636.  
For corrosive conditions hangers will be galvanized or painted with carbo-zinc #11.
- (z) All threads are UNC unless otherwise specified.

## A TYPICAL PIPE HANGER SPECIFICATION, CONT'D.

### HANGER DESIGN SERVICE

Hanger for piping 2½" and larger, and all spring support for assemblies, shall be completely engineered.

(a) Engineered hanger assemblies shall be detailed on 8½" x 11" sheets.

Each sketch will include a location plan showing the location of the hanger in relation to columns of equipment.

Each sketch will include an exact bill of material for the component parts making up each assembly.

(b) Each engineered hanger assembly will be individually bundled and tagged as far as practical, ready for installation.

Hanger material for piping 2" and smaller shall be shipped as loose material, identified by piping system only. A piping drawing marked with approximate hanger locations and types, and hanger sketches showing typical support arrangements will be furnished.

(c) Hanger inspections shall be performed in accordance with MSS-SP-89 (Section 7.7) and ASME B31.1 (Appendix V).

**TABLE 1: MAXIMUM HORIZONTAL SPACING BETWEEN PIPE SUPPORTS FOR STANDARD WEIGHT STEEL PIPE\***

	Nominal Pipe Size (in)																			
	½	¾	1	1½	2	2½	3	3½	4	5	6	8	10	12	14	16	18	20	24	30
<b>Max. Span (Ft) Water Service</b>	7	7	7	9	10	11	12	13	14	16	17	19	22	23	25	27	28	30	32	33
<b>Max. Span (Ft) Vapor Service</b>	8	9	9	12	13	14	15	16	17	19	21	24	26	30	32	35	37	39	42	34
<b>Recommended Hanger Rod Sizes</b>	⅜			½			⅝			¾			⅞			1			1 or trapeze	

The above spacing and capacities are based on pipe filled with water.

Additional valves and fittings increase the load and therefore closer hanger spacing is required.

\*Many codes and specifications state "pipe hangers must be spaced every 10ft. regardless of size." This local specification must be followed.

**TABLE 2: MAXIMUM HORIZONTAL SPACING BETWEEN COPPER TUBING SUPPORTS**

	Nominal Tubing Size (in)									
	½	¾	1	1¼	1½	2	2½	3	3½	4
<b>Max. Span (Ft) Water Service</b>	5	5	6	7	8	8	9	10	11	12
<b>Max. Span (Ft) Vapor Service</b>	6	7	8	9	10	11	13	14	15	16

**NOTE:** Spans shown in Tables 1 and 2 do not apply where there are concentrated loads between supports or where temperatures exceed 750°F.

## A TYPICAL PIPE HANGER SPECIFICATION, CONT'D.

**TABLE 3: LOAD CARRYING CAPACITIES OF THREADED HANGER RODS.**  
**MATERIALS CARBON STEEL WITH MINIMUM ACTUAL TENSILE STRENGTH OF 50 KSI.**

Rod Diameter (in)	Threads per Inch	Root Area of Coarse Thread (in <sup>2</sup> )	Maximum Safe Load (lbs) Rod Temperature, 650° F	Maximum Safe Load (lbs) Rod Temperature, 750° F
3/8	16	0.068	730	572
1/2	13	0.126	1,350	1,057
5/8	11	0.202	2,160	1,692
3/4	10	0.302	3,230	2,530
7/8	9	0.419	4,480	3,508
1	8	0.552	5,900	4,620
1 1/4	7	0.889	9,500	7,440
1 1/2	6	1.293	13,800	10,807
1 3/4	5	1.744	18,600	14,566
2	4 1/2	2.292	24,600	19,265
2 1/4	4 1/2	3.021	32,300	25,295
2 1/2	4	3.716	39,800	31,169
2 3/4	4	4.619	49,400	38,687
3	4	5.621	60,100	47,066
3 1/4	8 UN	6.720	71,900	56,307
3 1/2	8 UN	7.918	84,700	66,331
3 3/4	8 UN	9.214	98,500	77,139
4	8 UN	10.608	113,400	88,807
4 1/4	8 UN	12.100	129,400	101,337
4 1/2	8 UN	13.690	146,600	114,807
4 3/4	8 UN	15.379	164,700	128,982
5	8 UN	17.165	184,000	144,096

Standard UNC thread thru 3" diameter and 8-UN-2A thread series for 3 1/4" diameter and larger.

## THERMAL EXPANSION OF PIPE MATERIAL

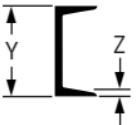
Temp F	THERMAL EXPANSION OF PIPE MATERIAL – (IN/FT)									
	Carbon Steel - Low Chrome Steel (thru 3% Cr)									
0	10	20	30	40	50	60	70	80	90	
-200	-0.0180	-0.0187	-0.0192	-0.0198	-0.0203	-0.0209	-0.0215	-0.0220	-0.0225	-0.0230
-100	-0.0121	-0.0127	-0.0133	-0.0140	-0.0146	-0.0152	-0.0158	-0.0163	-0.0169	-0.0174
-0	-0.0051	-0.0058	-0.0065	-0.0073	-0.0080	-0.0087	-0.0096	-0.0103	-0.0109	-0.0116
0	-0.0051	-0.0044	-0.0037	-0.0029	-0.0022	-0.0015	-0.0007	0	0.0008	0.0015
100	0.0023	0.0030	0.0038	0.0046	0.0053	0.0061	0.0068	0.0076	0.0084	0.0091
200	0.0099	0.0107	0.0116	0.0124	0.0132	0.0141	0.0149	0.0157	0.0165	0.0174
300	0.0182	0.0191	0.0200	0.0208	0.0217	0.0226	0.0235	0.0244	0.0252	0.0261
400	0.0270	0.0279	0.0288	0.0298	0.0307	0.0316	0.0325	0.0334	0.0344	0.0353
500	0.0362	0.0372	0.0382	0.0391	0.0401	0.0411	0.0421	0.0431	0.0440	0.0450
600	0.0460	0.0470	0.0481	0.0491	0.0501	0.0512	0.0522	0.0532	0.0542	0.0553
700	0.0563	0.0574	0.0584	0.0595	0.0606	0.0617	0.0627	0.0638	0.0649	0.0659
800	0.0670	0.0681	0.0692	0.0703	0.0714	0.0726	0.0737	0.0748	0.0759	0.0770
900	0.0781	0.0792	0.0803	0.0813	0.0824	0.0835	0.0846	0.0857	0.0867	0.0878
1,000	0.0889	0.0901	0.0912	0.0924	0.0935	0.0946	0.0958	0.0970	0.0981	0.0993
1,100	0.1004	0.1015	0.1025	0.1036	0.1046	0.1057	0.1068	0.1078	0.1089	0.1099
1,200	0.1110	0.1121	0.1132	0.1144	0.1155	0.1166	0.1177	0.1188	0.1200	0.1211
1,300	0.1222	0.1233	0.1244	0.1256	0.1267	0.1278	0.1299	0.1320	0.1342	0.1363
1,400	0.1334	-	-	-	-	-	-	-	-	-

## THERMAL EXPANSION OF PIPE MATERIAL

Temp F	THERMAL EXPANSION OF PIPE MATERIAL – (IN/FT)									
	Austenitic Stainless Steels (304, 316, 347)									
	0	10	20	30	40	50	60	70	80	90
-200	-0.0281	-0.0295	-0.0305	-0.0314	-0.0324	-0.0334	-0.0343	-0.0353	-0.0362	-0.0372
-100	-0.0187	-0.0197	-0.0207	-0.0216	-0.0226	-0.0236	-0.0245	-0.0254	-0.0263	-0.0272
-0	-0.0078	-0.0089	-0.0100	-0.0112	-0.0123	-0.0134	-0.0145	-0.0155	-0.0166	-0.0176
0	-0.0078	-0.0067	-0.0056	-0.0044	-0.0033	-0.0022	-0.0011	0	0.0012	0.0023
100	0.0034	0.0045	0.0056	0.0068	0.0079	0.0090	0.0101	0.0112	0.0124	0.0135
200	0.0146	0.0158	0.0169	0.0181	0.0192	0.0203	0.0215	0.0227	0.0238	0.0250
300	0.0261	0.0273	0.0285	0.0297	0.0309	0.0321	0.0332	0.0344	0.0356	0.0368
400	0.0380	0.0392	0.0404	0.0416	0.0428	0.0440	0.0453	0.0465	0.0477	0.0489
500	0.0501	0.0513	0.0526	0.0538	0.0550	0.0562	0.0575	0.0587	0.0599	0.0612
600	0.0624	0.0637	0.0649	0.0662	0.0674	0.0687	0.0700	0.0712	0.0725	0.0737
700	0.0750	0.0763	0.0776	0.0789	0.0802	0.0815	0.0828	0.0841	0.0854	0.0867
800	0.0880	0.0893	0.0906	0.0920	0.0933	0.0946	0.0959	0.0972	0.0986	0.0999
900	0.1012	0.1260	0.1039	0.1053	0.1066	0.1080	0.1094	0.1107	0.1121	0.1134
1,000	0.1148	0.1162	0.1175	0.1189	0.1202	0.1216	0.1229	0.1243	0.1257	0.1270
1,100	0.1284	0.1298	0.1311	0.1325	0.1338	0.1352	0.1366	0.1379	0.1393	0.1406
1,200	0.1420	0.1434	0.1447	0.1461	0.1474	0.1488	0.1502	0.1515	0.1529	0.1542
1,300	0.1556	0.1570	0.1583	0.1597	0.1610	0.1624	0.1638	0.1651	0.1665	0.1678
1,400	0.1692	0.1704	0.1717	0.1731	0.1744	0.1757	0.1771	0.1784	0.1796	0.1811

**NOTE:** Intersect "10" Degree increments across the top of each table with the "100" degree increments down the left side to determine the coefficient of thermal expansion for the desired temperature.

## BEAM DIMENSIONS



AMERICAN STANDARD CHANNELS

Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
3	4.1	1 $\frac{1}{8}$	0.250
	5.0	1 $\frac{1}{2}$	
	6.0	1 $\frac{5}{8}$	
4	5.4	1 $\frac{1}{8}$	0.313
	7.25	1 $\frac{3}{4}$	
5	6.7	1 $\frac{3}{4}$	0.313
	9.0	1 $\frac{7}{8}$	
6	8.2	1 $\frac{7}{8}$	0.375
	10.5	2	
	13.0	2 $\frac{1}{8}$	
7	9.8	2 $\frac{1}{8}$	0.375
	12.25	2 $\frac{1}{4}$	
	14.75	2 $\frac{1}{4}$	
8	11.5	2 $\frac{1}{4}$	0.375
	13.75	2 $\frac{5}{8}$	
	18.75	2 $\frac{1}{2}$	

AMERICAN STANDARD CHANNELS

Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
9	13.4	2 $\frac{3}{8}$	0.438
	15.0	2 $\frac{1}{2}$	
	20.0	2 $\frac{5}{8}$	
10	15.3	2 $\frac{5}{8}$	0.438
	20.0	2 $\frac{3}{4}$	
12	25.0	2 $\frac{7}{8}$	0.500
	30.0	3	
	20.7	3	
15	25.0	3	0.625
	30.0	3 $\frac{1}{8}$	
	33.9	3 $\frac{3}{8}$	
18	40.0	3 $\frac{1}{2}$	0.625
	50.0	3 $\frac{3}{4}$	
	42.7	4	
	45.8	4	0.625
	51.9	4 $\frac{1}{8}$	
	58.0	4 $\frac{1}{4}$	



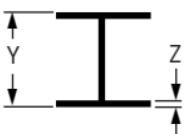
S SHAPES

Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
3	5.7	2 $\frac{3}{8}$	0.250
	7.5	2 $\frac{1}{2}$	
4	7.7	2 $\frac{5}{8}$	0.313
	9.5	2 $\frac{3}{4}$	
5	10.0	3	0.313
	14.75	3 $\frac{1}{4}$	
6	12.5	3 $\frac{3}{8}$	0.375
	17.25	3 $\frac{5}{8}$	
7	15.3	3 $\frac{5}{8}$	0.375
	20.0	3 $\frac{7}{8}$	
8	18.4	4	0.438
	23.0	4 $\frac{1}{8}$	
10	25.4	4 $\frac{5}{8}$	0.500
	35.0	5	
12	31.8	5	0.563
	35.0	5 $\frac{1}{8}$	
	40.8	5 $\frac{1}{4}$	
	50.0	5 $\frac{1}{2}$	

S SHAPES

Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
15	42.9	5 $\frac{1}{2}$	0.625
	50.0	5 $\frac{5}{8}$	
18	54.7	6	0.688
	70.0	6 $\frac{1}{4}$	
20	66.0	6 $\frac{1}{4}$	0.813
	75.0	6 $\frac{3}{8}$	
20.3	86.0	7	0.938
	96.0	7 $\frac{1}{4}$	
24	80.0	7	0.875
	90.0	7 $\frac{1}{8}$	
	100.0	7 $\frac{1}{4}$	

## BEAM DIMENSIONS



W SHAPES			
Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
5	19	5	0.430
6	25	6 $\frac{1}{8}$	0.455
8	18	5 $\frac{1}{4}$	0.330
	21	5 $\frac{1}{4}$	0.400
	24	6 $\frac{1}{2}$	0.400
	28	6 $\frac{1}{2}$	0.465
	31	8	0.435
	35	8	0.495
	40	8 $\frac{1}{8}$	0.560
	48	8 $\frac{1}{8}$	0.685
	58	8 $\frac{1}{4}$	0.810
	67	8 $\frac{1}{4}$	0.935
	22	5 $\frac{3}{4}$	0.360
	26	5 $\frac{3}{4}$	0.440
10	30	5 $\frac{3}{4}$	0.510
	33	8	0.435
	39	8	0.530
	45	8	0.620
	49	10	0.560
	54	10	0.615
	60	10 $\frac{1}{8}$	0.680
	68	10 $\frac{1}{8}$	0.770
	77	10 $\frac{1}{4}$	0.870
	88	10 $\frac{1}{4}$	0.990

W SHAPES			
Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
12	26	6 $\frac{1}{2}$	0.380
	30	6 $\frac{1}{2}$	0.440
	35	6 $\frac{1}{2}$	0.520
	40	8	0.515
	45	8	0.575
	50	8 $\frac{1}{8}$	0.640
	53	10	0.575
	58	10	0.640
	65	12	0.605
	72	12	0.670
	79	12 $\frac{1}{8}$	0.735
	87	12 $\frac{1}{8}$	0.810
	96	12 $\frac{1}{8}$	0.900
	106	12 $\frac{1}{4}$	0.990

W SHAPES			
Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
14	30	6 $\frac{3}{4}$	0.385
	34	6 $\frac{3}{4}$	0.455
	38	6 $\frac{3}{4}$	0.515
	43	8	0.530
	48	8	0.595
	53	8	0.660
	61	10	0.645
	68	10	0.720
	74	10 $\frac{1}{8}$	0.785
	82	10 $\frac{1}{8}$	0.855
	90	14 $\frac{1}{2}$	0.710
	99	14 $\frac{5}{8}$	0.780
	109	14 $\frac{5}{8}$	0.860
	120	14 $\frac{5}{8}$	0.940
	132	14 $\frac{3}{4}$	1.030
16	36	7	0.430
	40	7	0.505
	45	7	0.565
	50	7 $\frac{1}{8}$	0.63
	57	7 $\frac{1}{8}$	0.715
	67	10 $\frac{1}{4}$	0.665
	77	10 $\frac{1}{4}$	0.760
	89	10 $\frac{1}{8}$	0.875
	100	10 $\frac{1}{8}$	0.985

## BEAM DIMENSIONS, CONT'D.



W SHAPES			
Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
18	50	7½	0.570
	55	7½	0.630
	60	7½	0.695
	65	7½	0.750
	71	7½	0.810
	76	11	0.680
	86	11½	0.770
	97	11½	0.870
	106	11¼	0.940
21	62	8¼	0.615
	68	8¼	0.685
	73	8¼	0.740
	83	8¾	0.835
	93	8¾	0.930
	101	12¼	0.800
	111	12¾	0.875
	122	12¾	0.960
	76	9	0.680
24	84	9	0.770
	94	9½	0.875
	104	12¾	0.750
	117	12¾	0.850
	131	12¾	0.960

W SHAPES			
Nom. Size Y	Weight per Ft., lb.	Flange Width	Thick. of Flange Z
27	94	10	0.745
	102	10	0.830
	114	10½	0.930
	146	14	0.975
30	108	10½	0.760
	116	10½	0.850
	124	10½	0.930
	132	10½	1.000
33	118	11½	0.740
	130	11½	0.855
	141	11½	0.960
36	135	12	0.790
	150	12	0.940
	160	12	1.020

MAXIMUM RECOMMENDED  
APPLIED TORQUESFOR SET SCREWS IN MSS  
TYPE 19 & 23 C-CLAMP

Thread Size	Torque Value (in.- lbs)
1/4	40
5/8	60
1/2	125
5/8	250
3/4	400
7/8	665

Extracted from MSS-SP-69

## FOR FIG. 261 RISER CLAMP

Bolt Size	Torque Value (ft.- lbs)
1/4	6
5/8	21
1/2	46
5/8	100
3/4	150
7/8	190
1	280

Bolts per ASTM A307

Nuts per ASTM A563

## STEEL PIPE DATA

## STEEL PIPE DATA — SCHEDULE NO 40 &amp; 80

Nom. Size	O.D.	Schedule No.	Wall Thick.	Weight per Foot (lbs)	Weight of Water per Foot (lbs)
$\frac{3}{8}$	0.675	40	0.091	0.567	0.083
		80	0.126	0.738	0.061
$\frac{1}{2}$	0.840	40	0.109	0.850	0.132
		80	0.147	1.087	0.101
$\frac{3}{4}$	1.050	40	0.113	1.130	0.230
		80	0.154	1.473	0.186
1	1.315	40	0.133	1.678	0.374
		80	0.179	2.171	0.311
$\frac{1}{4}$	1.660	40	0.140	2.272	0.647
		80	0.191	2.996	0.555
$\frac{1}{2}$	1.900	40	0.145	2.717	0.882
		80	0.200	3.631	0.765
2	2.375	40	0.154	3.652	1.452
		80	0.218	5.022	1.279
$\frac{5}{8}$	2.875	40	0.203	5.790	2.072
		80	0.276	7.660	1.834
3	3.500	40	0.216	7.570	3.200
		80	0.300	10.250	2.860
$\frac{7}{8}$	4.000	40	0.226	9.110	4.280
		80	0.318	12.510	3.850
4	4.500	40	0.237	10.790	5.510
		80	0.337	14.980	4.980

## STEEL PIPE DATA — SCHEDULE NO 40 &amp; 80

Nom. Size	O.D.	Schedule No.	Wall Thick.	Weight per Foot (lbs)	Weight of Water per Foot (lbs)
5	5.563	40	0.258	14.620	8.660
		80	0.375	20.780	7.870
6	6.625	40	0.280	18.970	12.510
		80	0.432	28.570	11.290
8	8.625	40	0.322	28.550	21.600
		80	0.500	43.390	19.800
10	10.750	40	0.365	40.480	34.100
		80	0.593	64.400	31.100
12	12.75	40	0.406	53.600	48.500
		80	0.687	88.600	44.000
14	14.000	40	0.437	63.000	58.500
		80	0.750	107.000	51.200
16	16.000	40	0.500	83.000	76.500
		80	0.843	137.000	69.700
18	18.000	40	0.563	105.000	97.200
		80	0.937	171.000	88.500
20	20.000	40	0.593	123.000	120.400
		80	1.031	209.000	109.400
24	24.000	40	0.687	171.000	174.200
		80	1.218	297.000	158.200
30	30.000	20	0.500	158.000	286.000
36	36.000	API	0.500	190.000	417.000

## COPPER TUBE DATA

TYPE L					
Tube Size	O.D. Tubing	O.D.	Wall Thick.	Weight per Foot (lbs)	Weight of Water per Foot (lbs)
1/4	3/8	0.375	0.030	0.126	0.034
5/16	1/2	0.500	0.035	0.198	0.062
1/2	5/8	0.625	0.040	0.285	0.100
5/8	3/4	0.750	0.042	0.362	0.151
3/4	7/8	0.875	0.045	0.455	0.209
1	1 1/8	1.125	0.050	0.655	0.357
1 1/4	1 1/8	1.375	0.055	0.884	0.546
1 1/2	1 5/8	1.625	0.060	1.140	0.767
2	2 1/8	2.125	0.070	1.750	1.341
2 1/2	2 5/8	2.625	0.080	2.480	2.064
3	3 1/8	3.125	0.090	3.330	2.949
3 1/2	3 5/8	3.625	0.100	4.290	3.989
4	4 1/8	4.125	0.110	5.380	5.188
5	5 1/8	5.125	0.125	7.610	8.081
6	6 1/8	6.125	0.140	10.200	11.616
8	8 1/8	8.125	0.200	19.290	20.289
10	10 1/8	10.125	0.250	30.100	31.590
12	12 1/8	12.125	0.280	40.400	45.426

TYPE K					
Tube Size	O.D. Tubing	O.D.	Wall Thick.	Weight per Foot (lbs)	Weight of Water per Foot (lbs)
1/4	3/8	0.375	0.035	0.145	0.032
5/16	1/2	0.500	0.049	0.269	0.055
1/2	5/8	0.625	0.049	0.344	0.094
5/8	3/4	0.750	0.049	0.418	0.144
3/4	7/8	0.875	0.065	0.641	0.188
1	1 1/8	1.125	0.065	0.839	0.337
1 1/4	1 1/8	1.375	0.065	1.040	0.527
1 1/2	1 5/8	1.625	0.072	1.360	0.743
2	2 1/8	2.125	0.083	2.060	1.310
2 1/2	2 5/8	2.625	0.095	2.920	2.000
3	3 1/8	3.125	0.109	4.000	2.960
3 1/2	3 5/8	3.625	0.120	5.120	3.900
4	4 1/8	4.125	0.134	6.510	5.060
5	5 1/8	5.125	0.160	9.670	8.000
6	6 1/8	6.125	0.192	13.870	11.200
8	8 1/8	8.125	0.271	25.900	19.500
10	10 1/8	10.125	0.338	40.300	30.423
12	12 1/8	12.125	0.405	57.800	43.675

## OTHER PIPE DATA

FLANGE CAST IRON PIPE ADD WEIGHT OF FLANGES *					
Pipe Size	Class	O.D. C.I. Pipe	Wall Thick.	Weight per ft. (lbs)	Weight of Water per ft. (lbs).
3	150	3.96	0.32	12.2	3.7
4	150	4.80	0.32	16.4	5.7
6	150	6.90	0.38	25.7	12.8
8	150	9.05	0.41	36.7	23.1
10	150	11.10	0.44	48.7	35.5
12	150	13.20	0.48	62.9	51.0
14	150	15.30	0.51	78.8	69.3
16	150	17.40	0.54	95.0	90.3
18	150	19.50	0.58	114.7	114.0
20	150	21.60	0.62	135.9	141.5
24	150	25.80	0.73	190.4	201.0
30	150	32.00	0.85	277.3	312.0
36	150	38.30	0.94	368.9	449.0
42	150	44.50	1.05	479.1	612.0
48	150	50.80	1.14	595.2	803.0

\* Mechanical joint pipe class ISO is approximately the same weight as Bell & Spigot

GLASS PIPE - REGULAR SCHEDULE				
Pipe Size	O.D.	Wall Thick.	Weight/ft. (lbs)	Weight of Water per ft. (lbs)
1½	1.84	0.12	0.64	0.89
2	2.34	0.14	0.94	1.45
3	3.41	0.17	1.60	3.19
4	4.53	0.20	2.60	5.79
6	6.66	0.24	4.70	12.78

GLASS PIPE - HEAVY SCHEDULE				
Pipe Size	O.D.	Wall Thick.	Weight per ft. (lbs)	Weight of Water per ft. (lbs)
1	1.31	0.16	0.6	0.35
1½	1.84	0.17	0.9	0.76
2	2.34	0.17	1.1	1.36
3	3.41	0.20	2.0	3.06
4	4.53	0.26	3.4	5.44
6	6.66	0.33	6.3	12.42

## PVC PIPE SUPPORT SPACING

Pipe Size (in.)	SCHEDULE 40 — Temperature (°F)					SCHEDULE 80 — Temperature (°F)					SCHEDULE 120 — Temperature (°F)				
	60	80	100	120	140	60	80	100	120	140	60	80	100	120	140
1/4	4	3½	3½	2	2	4	4	3½	2½	2	-	-	-	-	-
5/8	4	4	3½	2½	2	4½	4½	4	2½	2½	-	-	-	-	-
1/2	4½	4½	4	2½	2½	5	4½	4½	3	2½	5	5	4½	3	2½
¾	5	4½	4	2½	2½	5½	5	4½	3	2½	5½	5	4½	3	3
1	5½	5	4½	3	2½	6	5½	5	3½	3	6	5½	5	3½	3
1¼	5½	5½	5	3	3	6	6	5½	3½	3	6½	6	5½	3½	3½
1½	6	5½	5	3½	3	6½	6	5½	3½	3½	6½	6½	6	4	3½
2	6	5½	5	3½	3	7	6½	6	4	3½	7½	7	6½	4	3½
2½	7	6½	6	4	3½	7½	7½	6½	4½	4	8	7½	7	4½	4
3	7	7	6	4	3½	8	7½	7	4½	4	8½	8	7½	5	4½
3½	7½	7	6½	4	4	8½	8	7½	5	4½	9	8½	7½	5	4½
4	7½	7	6½	4½	4	9	8½	7½	5	4½	9½	9	8½	5½	5
5	8	7½	7	4½	4	9½	9	8	5½	5	10½	10	9	6	5½
6	8½	8	7½	5	4½	10	9½	9	6	5	11½	10½	9½	6½	6
8	9	8½	8	5	4½	11	10½	9½	6½	5½	-	-	-	-	-
10	10	9	8½	5½	5	12	11	10	7	6	-	-	-	-	-
12	11½	10½	9½	6½	5½	13	12	10½	7½	6½	-	-	-	-	-
14	12	11	10	7	6	13½	13	11	8	7	-	-	-	-	-
16	12½	11½	10½	7½	6½	14	13½	11½	8½	7½	-	-	-	-	-
18	13	12	11	8	7	14½	14	12	11	9	-	-	-	-	-
20	14	12½	11½	10	8½	15½	14½	12½	11½	9½	-	-	-	-	-
24	15	13	12½	11	9½	17	15	14	12½	10½	-	-	-	-	-

**PVC PIPE SUPPORT SPACING, CONT'D.**

Pipe Size (in.)	SDR 41					SDR 26					-				
	60	80	100	120	140	60	80	100	120	140	60	80	100	120	140
18	13	12	11	8	7	14½	14	12	9	8	-	-	-	-	-
20	13½	12½	11½	8½	7½	15	14½	12½	9½	8½	-	-	-	-	-
24	14	13	12	9	8	15½	15	13	10	9	-	-	-	-	-

**NOTE:** Although support spacing is shown at 140°F, consideration should be given to the use of CPVC or continuous support above 120°F.

The possibility of temperature overrides beyond regular working temperatures and cost may either make either of the alternatives more desirable.  
This chart based on continuous spans and for un-insulated line carrying fluids of specific gravity up to 1.00.

The above table is meant as a general guideline, it is recommended that the pipe manufacturer be consulted for specific spacing recommendations relating to their pipe, load conditions, operating temperature and service conditions.

Local codes and specifications may also vary from the above recommended spacing and should be consulted for the applicable spacing requirements prior to installation.

## CPVC PIPE SUPPORT SPACING

Pipe Size (in.)	SCHEDULE 40 — Temperature (°F)						SCHEDULE 80 — Temperature (°F)					
	73°	100°	120°	140°	160°	180°	73°	100°	120°	140°	160°	180°
½	5	4½	4½	4	2½	2½	5½	5	4½	4½	3	2½
¾	5	5	4½	4	2½	2½	5½	5½	5	4½	3	2½
1	5½	5½	5	4½	3	2½	6	6	5½	5	3½	3
1¼	5½	5½	5½	5	3	3	6½	6	6	5½	3½	3
1½	6	6	5½	5	3½	3	7	6½	6	5½	3½	3½
2	6	6	5½	5	3½	3	7	7	6½	6	4	3½
2½	7	7	6½	6	4	3½	8	7½	7½	6½	4½	4
3	7	7	7	6	4	3½	8	8	7½	7	4½	4
3½	7½	7½	7	6½	4	4	8½	8½	8	7½	5	4½
4	7½	7½	7	6½	4½	4	8½	9	8½	7½	5	4½
6	8½	8	7½	7	5	4½	10	9½	9	8	5½	5
8	9½	9	8½	7½	5½	5	11	10½	10	9	6	5½
10	10½	10	9½	8	6	5½	11½	11	10½	9½	6½	6
12	11½	10½	10	8½	6½	6	12½	12	11½	10½	7½	6½
14	12	11	10	9	8	6	15	13½	12½	11	9½	8
16	13	12	11	9½	8½	7	16	15	13½	12	10	8½

**NOTE:** Although support spacing is shown at 140°F, consideration should be given to the use of CPVC or continuous support above 120°F.

The possibility of temperature overrides beyond regular working temperatures and cost may either make either of the alternatives more desirable.  
This chart based on continuous spans and for un-insulated line carrying fluids of specific gravity up to 1.00.

The above table is meant as a general guideline, it is recommended that the pipe manufacturer be consulted for specific spacing recommendations relating to their pipe, load conditions, operating temperature and service conditions.

Local codes and specifications may also vary from the above recommended spacing and should be consulted for the applicable spacing requirements prior to installation.

*Anvil offers both Basic and Extended Services...  
Contact your Anvil representative for more information.*

### BASIC SERVICES

Anvil Design Services produces fabrication drawings and Bill of Materials of mechanical room piping 2½" and larger including chillers, heat exchangers, boilers, and pumps from contractor supplied flow diagrams, mechanical drawings, and approved submittals and specifications.

Initially, Anvil personnel meet with you to determine your piping preferences. The project scope and fee is agreed upon in a Design Services contract.

The plans and specifications are then interpreted in terms of economy, accuracy, and compliance. We may suggest modifications in arrangement, construction, equipment location, or product to attain the desired results. Piping layouts are carefully analyzed to determine whether further economies can be attained in the piping system.

Piping drawings are then prepared to determine the most efficient pipe routing, taking equipment location and any interferences into consideration. Preliminary prints are sent to you for revision or approval.

Upon approval, (4) sets of drawings with tags and Bills of Materials of the included system components are sent to you.

With Basic Services, you can plan the mechanical room. The preliminary drawings can be taken to coordination meetings with other trades

### ANVIL PIPE FITTERS HANDBOOK

### VALVES

Qty	TAG#	SIZE	PART#	DESCRIPTION #1
	4	2.5	GRUVLOK,SER.7000	BUTTERFLY VALVE, GRVD
	25	2.5	GRUVLOK,FIG.758	STRAINER, GROOVED
	27	2.5	GRUVLOK,SER.7800	CHECK VALVE, GRVD
	34	6	GRUVLOK,FIG.7260	STRAINER, GROOVED
	55	10	GRUVLOK,SER.7000	BUTTERFLY VALVE, GRVD
12	58	6	GRUVLOK,SER.7000	BUTTERFLY VALVE, GRVD
	61	10	GRUVLOK,SER.7000	BUTTERFLY VALVE, GRVD
	81	6	GRUVLOK,FIG.722G	3DTY VALVE, GROOVED
	85	6x5	GRUVLOK,FIG.7250	SUCTION DIFF, GROOVED
	89	6	GRUVLOK,FIG.7250	SUCTION DIFF, GROOVED

### FITTINGS

Qty	TAG#	SIZE	PART#	DESCRIPTION #1	DESCRIPTION #2
10	2	2.5	GRUVLOK,FIG.7050	90 ELBOW, GRVD	290390014249
27	5	2.5	GRUVLOK,FIG.7000	COUPLING, FLEX GRVD.	
32	7	2.5	GRUVLOK,FIG.7400	COUPLING, RIGIDLOK GRVD.	290390013522
6	8	2.5	GRUVLOK,FIG.7060	TEE, GROOVED	290390016882
4				45 ELBOW, GRVD	290390014249

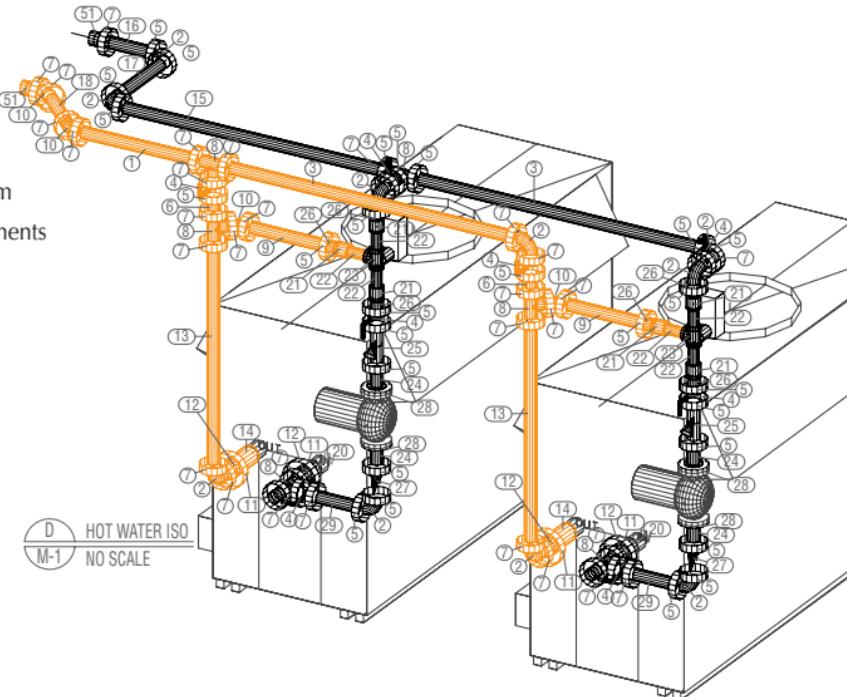
to "reserve" space by "getting in" first. Also, your field supervisor can spend more time supervising and not calculating pipe lengths and pipe routing. The components can be grouped from the finished drawings for better workflow planning.

We usually reduce fitting counts by 10%-15% by moving equipment whenever possible, usually less than a foot. The more movement that is allowed, the more savings can be realized.

**EXTENDED SERVICES**

Extended Services include any scope beyond Basic Services. There are many different types of services offered as extended:

- BOM by component (pump, chiller) or by system
- Unique Tagging – adding unique tags to components
- Air Handling Units – with associated ductwork
- Single Line Routing – non-dimensional
- Distribution Piping
- Dimensioned Floor Penetrations
- AWWA Piping - Total Scope
- Commercial Piping
- Oil Field Piping
- Retrofit Projects - Field Survey
- Hybrid Systems
- Anything Else



**ALPHABETICAL INDEX**

<b>Description.....</b>	<b>Page</b>	<b>Description.....</b>	<b>Page</b>
Abbreviations .....	205 - 206	Copper Tube Data.....	292
Advanced Copper Method .....	113 - 122	Coupling Chart Data Notes .....	262
Alignment of Pipe.....	223 - 224	Coupling Flexibility .....	269 - 272
Alphabetical Index.....	309 - 311	Couplings for Grooved-End Pipe .....	6 - 23
Anvil Design Services .....	307 - 308	CPVC Pipe Support Spacing .....	296
Approvals and Listings.....	315	Cut Groove Specifications .....	280 - 283
Approximate Temperature For Carbon Steel, Colors .....	228	Decimal Degree Equivalents Of Minutes.....	205
Arc Welding Equipment, Trouble Shooting .....	241 - 243	Decimal Equivalents Of Fractions .....	205
ASTM Carbon Steel Pipe & Flange Specifications .....	220 - 221	Design Factors .....	255
Barlow's Formula .....	208	Design Services .....	307 - 308
Basic Arc & Gas Welding Symbols .....	244 - 245	Drill Sizes For NPT Pipe Taps .....	223
Beam Dimensions .....	298 - 300	Equivalents Of Minutes, Decimal Degree.....	205
Blind Flanges.....	215	Extra Heavy Cast Iron Companion Flanges & Bolts .....	215
Boiling Points Of Water At Various Pressures.....	224	Feet Head To Water Pressure .....	225
Bolt Torque.....	200	Figure Number Index .....	312 - 314
Bolting Dimensions for 150 to 300 Lb. Steel Flange .....	216	Fitting Size O.D. Chart & Flow Data Frictional Resistance .....	146
Bolting Dimensions for 400 Lb./600Lb. Steel Flange .....	217	Fittings for Grooved-End Pipe .....	36 - 80
Branch Outlets .....	24 - 35	Flange & Carbon Steel Pipe Specifications, ASTM .....	220 - 221
Carbon Steel Pipe & Flange Specifications, ASTM .....	220 - 221	Flow Control Components.....	258 - 259
Coated Arc Welding Electrodes - Types & Styles .....	238	Flow Conversion Chart.....	228 - 229
Colors And Approximate Temperature For Carbon Steel .....	228	Flow Data Frictional Resistance.....	146
Commercial Pipe Sizes & Wall Thicknesses.....	208 - 209	Formulas, Geometry .....	234
Conversions .....	238 - 239	Formulas, Sprinkler System .....	235
Copper Fittings.....	113 - 122	Fractions, Decimal Equivalents Of .....	205

## ALPHABETICAL INDEX, CONT'D.

<b>Description.....</b>	<b>Page</b>	<b>Description.....</b>	<b>Page</b>
Gasket Grade Index & Gasket Recommendations .....	262 - 263	Installation - Fig. 7045 7046 Clamp-T® Branch Outlets .	172 - 173
General Assembly of Threaded Fittings .....	199	Installation - Fig. 7305 HDPE Coupling .....	178 - 179
Geometry Formulas .....	234	Installation - Fig. 7307 HDPE Transition Coupling.....	180 - 181
Gruvlok DI-LOK® Nipples .....	123	Installation - Fig. 7312 HDPE Flange Adapter.....	182 - 183
Gruvlok® Flow Control Components .....	258 - 259	Installation - Fig. 7400 Rigidlite® Coupling .....	158 - 159
Gruvlok® Gasket Styles .....	260 - 261	Installation - Fig. 7401 Rigidlok® Coupling .....	154 - 155
Gruvlok® Lubricants .....	255 - 256	Installation - Fig. AF21-GG, -GF & -FF AnvilFlex™ .....	192 - 193
Gruvlok® Product Information .....	6 - 148	Installation - Fig. GBV-S & GBV-T Circuit Balancing Valves	186 - 191
Hardness Conversion Numbers .....	237	Installation - General Assembly of Threaded Fittings .....	199
HDPE Couplings.....	131 - 132	Installation - Gruvlok Sock-It® Fitting .....	184 - 185
Heat Losses From Horizontal Bare Steel Pipe .....	228	Installation - Specified Bolt Torque .....	200
High Pressure Systems.....	110 - 112	Installation - Weld-Miser™ Tee-Lets® .....	194 - 197
How to Cut Odd-Angle Elbows .....	220	Installation & Assembly .....	149 - 202
Installation - Eliminator Adjustable Drop Nipples.....	198 - 200	Lap Joint Flanges .....	214
Installation - Fig. 7000 Standard Coupling .....	156 - 157	List Of Abbreviations.....	205 - 206
Installation - Fig. 7001 Standard Coupling .....	150 - 151	Listings and Approvals.....	315
Installation - Fig. 7003 Hingelok™ Coupling .....	160 - 161	Lubricants .....	255 - 256
Installation - Fig. 7005 Roughneck® Coupling .....	176 - 177	Maximum Recommended Applied Torques.....	290
Installation - Fig. 7010 Reducing Coupling .....	162 - 163	Melting Points of Metals .....	230
Installation - Fig. 7011 Standard Coupling .....	152 - 153	Movement—Applications .....	265 - 268
Installation - Fig. 7012 Gruvlok Flange (14" - 24").....	168 - 169	NPT Pipe Taps, Drill Sizes .....	223
Installation - Fig. 7012 Gruvlok Flange (2" - 12").....	164 - 167	Other Pipe Data.....	293
Installation - Fig. 7042 Outlet Coupling .....	170 - 171	Physical Properties of E60 & E70 Series Electrodes .....	238
Installation - Fig. 7044 Branch Outlet.....	174 - 175	Pipe & Water Weight/Foot.....	223

**ALPHABETICAL INDEX, CONT'D.**

<b>Description.....</b>	<b>Page</b>	<b>Description.....</b>	<b>Page</b>
Pipe Alignment.....	223 - 224	Tap & Drill Sizes.....	223
Pipe Data, Steel.....	291	Technical Information .....	203 - 308
Pipe Fitting Symbols .....	246 - 250	Thermal Expansion of Pipe Material.....	296 - 297
Pipe Hanger Specification .....	291 - 295	Thermal Expansion of Piping Material.....	228
Pipe Preparation .....	273 - 275	Threaded and Socket Flanges, Slip-on .....	213
Pipe Sizes & Wall Thicknesses, Commercial.....	208 - 209	Torque, Bolt.....	200
Pipe Support.....	276 - 290	Total Thermal Expansion of Piping Material .....	228
Plain-End Fittings.....	124 - 130	Trouble Shooting Arc Welding Equipment.....	241 - 243
Product Listings and Approvals .....	315	Tube Data, Copper.....	292
PVC Pipe Support Spacing.....	304 - 305	Typical BTU Values Of Fuels .....	229
Roll Groovers.....	146 - 147	Typical Pipe Hanger Specification .....	291 - 295
Roll Groove Specifications .....	276 - 279	Unit Conversions .....	233
Slip-on, Threaded and Socket Flanges .....	213	Useful Definitions .....	233 - 234
Sock-It® Piping Method Fittings .....	133 - 138	Vacume Service .....	259
Specific Gravity Of Gases .....	229	Valves & Accessories.....	81 - 109
Specific Gravity Of Liquids .....	229	Wall Thicknesses & Pipe Sizes, Commercial.....	208 - 209
Specified Bolt Torque .....	200	Water Pressure To Feet Head .....	225
Sprinkler System Formulas .....	235	Weight/Foot - Seamless Brass & Copper Pipe .....	224
Stainless Steel Method.....	139 - 145	Weights of Metals .....	228
Standard Cast Iron Companion Flanges & Bolts .....	213	Weld Fitting 90° Elbow, 180° Return, 45° Elbow .....	209
Standard Conversions .....	236	Weld Fitting Reducers & Reducing Outlet Tees.....	211
Standard Pipe Data .....	208	Weld Fitting Tee, Cap, Cross, Stub End .....	210
Steel Pipe Data.....	291	Weld Fitting Welding Neck Flanges .....	212
Symbols For Pipe Fittings .....	246 - 250	Wire Rope.....	251 - 253

**FIGURE NUMBER INDEX**

<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>	<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>
171	Brass Ball Valve .....	85-86	7050-5D	90° Long Radius Elbow .....	75
400G	Grooved-End Silent Check Valve.....	89	7050-6D	90° Long Radius Elbow .....	78
758G	Grooved-End "Wye" Strainer .....	100	7050DR	90° Drain Elbow.....	69
768G	Grooved-End "Wye" Strainer .....	101	7050EG	High Pressure 90° LR Elbow .....	112
1007	Roll Groovers.....	146	7050LR	90° Long Radius Elbow .....	40
3006C	Roll Groovers.....	146	7050LRP	Plain End 90° Long Radius Elbow.....	128
3006	Roll Groovers.....	147	7050P	Plain End 90° Elbow .....	125
3007	Roll Groovers.....	147	7050RF	Reducing Base Support Elbow (GR xFL).....	63
7000	Lightweight Coupling .....	12-13, 156-157	7050SS	Stainless Steel 90° Elbow .....	142
7001	Standard Coupling .....	6-8, 150-151	7050	90° Elbow .....	36
7003	Hingelok® Coupling .....	16, 160-161	7051-3D	45° Long Radius Elbow .....	73
7004EG	End Guard® Coupling.....	111	7051-5D	45° Long Radius Elbow .....	76
7004HPR	HPR® Coupling .....	110	7051-6D	45° Long Radius Elbow .....	79
7005	Roughneck® Coupling .....	124, 176-177	7051EG	High Pressure 45° LR Elbow .....	112
7010	Reducing Coupling .....	17-18, 162-163	7051LR	45° Long Radius Elbow .....	41
7011	Standard Coupling .....	9, 152-153	7051LRP	Plain End 45° Long Radius Elbow.....	128
7012	Gruvlok Flanges .....	19-21, 114-115, 164-169	7051P	Plain End 45° Elbow .....	125
7013	Gruvlok Flanges .....	22	7051SS	Stainless Steel 45° Elbow .....	142
7022EG	High Pressure Header Tee.....	112	7051	45° Elbow .....	37
7042	Outlet Coupling .....	24-25, 170-171	7052-3D	22½° Long Radius Elbow.....	74
7044	Branch Outlet.....	35, 174-175	7052-5D	22½° Long Radius Elbow.....	77
7045	Clamp-T®, FPT Branch.....	26-30, 172-173	7052-6D	22½° Long Radius Elbow.....	80
7046	Clamp-T®, Groove Branch .....	31-33, 172-173	7052	22½° Elbow.....	38
7047	Clamp-T®, Cross.....	34	7053-3D	11¼° Long Radius Elbow.....	74
7048	Clamp-T®, Cross.....	34	7053-5D	11¼° Long Radius Elbow.....	77
7049	Clamp-T®, Cross.....	34	7053-6D	11¼° Long Radius Elbow.....	80
7050-3D	90° Long Radius Elbow .....	72	7053	11¼° Elbow.....	39

**FIGURE NUMBER INDEX, CONT'D.**

<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>	<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>
7055	GR x MPT 90° Adapter Elbow .....	62	7071P	Plain End 90° True Wye .....	126
7056	GR x MPT 45° Adapter Elbow .....	62	7071	True Wye .....	61
7057-3D	60° Long Radius Elbow .....	72	7072SS	Stainless Steel Concentric Reducers .....	144
7057-5D	60° Long Radius Elbow .....	75	7072	GR x GR Concentric Reducers .....	53-54
7057-6D	60° Long Radius Elbow .....	78	7073	Eccentric Reducers .....	50-51
7058-3D	30° Long Radius Elbow .....	73	7074SS	Stainless Steel Caps .....	143
7058-5D	30° Long Radius Elbow .....	76	7074	Cap .....	65
7058-6D	30° Long Radius Elbow .....	79	7075P	Plain End Bull Plug .....	128
7060EG	High Pressure Tee .....	112	7075	Bull Plug .....	66
7060P	Plain End Tee .....	125	7076	GR x Thd Concentric Reducers .....	49
7060SS	Stainless Steel Tees .....	143	7077P	Plain End Swaged Nipples .....	130
7060	Tee .....	48	7077	Swaged Nipples (GR xGR) .....	52
7061P	Plain End Reducing Tee .....	127	7078	Swaged Nipples (GR xTHD) .....	52
7061SS	Stainless Steel Reducing Tees .....	144	7079	Swaged Nipples (GR xBEV) .....	52
7061	Reducing Tee Standard .....	43-45	7080P	Adapter Nipple (Plain x GR) .....	129
7062	Bullhead Tee Specialty Tees (GR x GR x FPT) .....	68	7080	Adapter Nipple (GR xGR) .....	67
7063	Tee w/ Threaded Branch .....	42	7081P	Adapter Nipple (Plain x THD) .....	129
7064	Reducing Tee w/ Threaded Branch .....	46-47	7081	Adapter Nipple (GR xMPT) .....	67
7065	Standpipe Tee (GR x GR x FPT) .....	68	7082P	Adapter Nipple (Plain x BEV) .....	129
7066	Tee Wye .....	58-59	7082	Adapter Nipple (GR xBEV) .....	67
7067	Reducing Tee Wye .....	60	7084P	Flange Nipples (Plain x #150 FL) .....	129
7068EG	High Pressure Cross .....	111	7084	Flange Nipples (GR x #150 FL) .....	64
7068P	Plain End Cross .....	126	7085P	Flange Nipples (Plain x #300 FL) .....	129
7068	Cross .....	66	7085	Flange Nipples (GR x #300 FL) .....	64
7069P	Plain End 45° Lateral .....	126	7086	HOSE Nipples (GR x Hose) .....	67
7069	45° Lateral .....	55	7087	Female Thread Adapter (GR x FPT) .....	63
7070	45° Reducing Lateral .....	56-57	7088	DI-LOK® Nipple (GR xTHD) .....	123

**FIGURE NUMBER INDEX, CONT'D.**

<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>	<b>Fig. No.</b>	<b>Description .....</b>	<b>Page</b>
7089	DI-LOK® Nipple (GR xGR) .....	123	7561A	Copper Reducing Tee (GR x GR x Gr) .....	118
7090	DI-LOK® Nipple (THD xTHD) .....	123	7564A	Copper Reducing Tee (GR x GR x CUP) .....	118
7091	End of the Line.....	70	7572	Copper Concentric Reducer (GR x Gr) .....	117
7097	Eccentric Reducers .....	50-51	7574	Copper End Caps .....	110
7100	Sock-It® 90° Elbow .....	133, 184-185	7575	Copper Reducing Adapter (GR x CUP) .....	120
7101	Sock-It® 90° Reducing Elbow .....	134, 184-185	7582	Copper Transition Fitting .....	120
7103	Sock-It® Straight Tee .....	135, 184-185	7600	Butterfly Valve.....	83
7105	Sock-It® Reducing Outlet Tee .....	136, 184-185	7700	Butterfly Valve.....	81-82
7106	Sock-It® Reducing Tee .....	137, 184-185	7800	Check Valves.....	90
7107	Sock-It® Coupling .....	138, 184-185	8000GR	Butterfly Valve.....	84
7240	Expansion Joints.....	23	AF21-FF	Flex Connectors (FL xFL) .....	109, 192-193
7250	Suction Diffuser .....	102-104	AF21-GF	Flex Connectors (GR x FL) .....	108, 192-193
7260	Tee Strainer.....	98-99	AF21-GG	Flex Connector (GR x GR) .....	107, 192-193
7305	HDPE Coupling .....	131, 178-179	FTV-A	Tri-Service Valves (Angle) .....	94-97
7307	HDPE Transition Coupling.....	131, 180-181	FTV-S	Tri-Service Valves (Straight) .....	94-97
7312	HDPE Flange Adapter .....	132, 182-183	GAV-15	Automatic Air Vents .....	105
7400SS	Stainless Steel Rigidlite® Coupling .....	139	GAV-30	Automatic Air Vents .....	106
7400	Rigidlite® Coupling .....	14-15, 113, 158-159	GBV-A	Balancing Valves (Angle) .....	91-92
7401	Rigidlok® Coupling .....	10-11, 154-155	GBV-G	Balancing Valves (Straight) .....	91-92
7450	90° Short Pattern Elbow .....	71	GBV-S	Circuit Balancing Valves (Sweat) .....	93, 186-191
7460	Short Pattern Tee .....	71	GBV-T	Circuit Balancing Valves (Threaded) .....	93, 186-191
7500B	Grooved-End Bronze Copper Ball Valve .....	121-122			
7500SS	Stainless Steel Grooved-End Ball Valve.....	140-141			
7500	Ball Valves .....	87-88			
7550	Copper 90° Elbow .....	116			
7551	Copper 45° Elbow .....	116			
7560	Copper Tees .....	116			

The Gruvllok® System has been manufactured since the late 1960's. The Gruvllok product line has grown from standard couplings and fittings to today's extensive range of grooved product, plain-end product, butterfly valves, check valves, pump protection components, pipe preparation tools and various accessories.



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<b>ABS</b>	American Bureau of Shipping	<b>BV</b>	Bureau Veritas	<b>MEA</b>	Materials & Equipment Acceptance	<b>SBCCI</b>	Southern Building Code Congress International: Standard Plumbing and Mechanical Code
<b>ANSI</b>	American National Standards Institute	<b>CDF</b>	California State Fire Marshal	<b>MIL</b>	Military Specifications: MILP-10388 Fittings; MIL-C-10387 Couplings; MIL-P-11087A(CE) Steel Pipe, Grooved MIL-I-45208 Inspection Procedure	<b>TVA</b>	Tennessee Valley Authority: Fire protection, storm drains
<b>API</b>	American Petroleum Institute: API Std. 5L, Sect. 7.5	<b>COE</b>	Corps of Engineers: CEGS 15000	<b>NASA</b>	National Aeronautics and Space Administration: 15000 Series	<b>UL</b>	Underwriter's Laboratories, Inc.
<b>ASHRAE</b>	American Society of Heating, Refrigerating and Air Conditioning Engineers	<b>CSA</b>	Canadian Standards Association: B-242	<b>NAVFAC</b>	Naval Facilities Engineering Command: NFGS 15000 Series	<b>ULC</b>	Underwriter's Laboratories of Canada, Bureau of Marine Inspection: Salt and fresh water, oil transfer, Bureau of Public Roads; Div. of Bridges: Drain lines and bridge crossings, Canadian Coast Guard
<b>ASME</b>	American Society of Mechanical Engineers: Power Piping, B-31.1; Chemical Plant and Petroleum Refinery Piping, B-31.3; Refrigeration Piping, B-31.5; Building Services Piping, B-31.9; Slurry Pipelines, B-31.11	<b>DNV</b>	Det Norske Veritas	<b>NFPA</b>	National Fire Protection Association	<b>USGBC</b>	U.S. Coast Guard – Approves each vessel individually
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<b>AWWA</b>	American Water Works Association: C-606	<b>FHA</b>	New Zealand Insurance Council	<b>NSF</b>	NSF International	<b>VdS</b>	Veterans Affairs : 15000 Series
		<b>FM</b>	New Zealand Building Act. (1991)	<b>NY-BSA</b>	New York Board of Standards and Appeals		Verband der Sachversicherer e.V.
		<b>GSA</b>	Federal Aviation Administration: HVAC, Plumbing, Fire Protection	<b>NYC</b>	New York City		
		<b>IAPMO</b>	Federal Housing Administration				
		<b>LLOYD'S</b>	Factory Mutual Engineering Corp.				
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